



Workshop Manual

Fox 2010 ➤

Fox 2014 ➤

SpaceFox 2011 ➤

General body repairs, exterior

Edition 01.2017



List of Workshop Manual Repair Groups

Repair Group

- 50 - Body - front
- 55 - Bonnet, rear lid
- 57 - Front doors, door components, central locking
- 58 - Rear doors, door components
- 60 - Sunroof
- 63 - Bumpers
- 64 - Glazing
- 66 - Exterior equipment

Technical information should always be available to the foremen and mechanics, because their careful and constant adherence to the instructions is essential to ensure vehicle road worthiness and safety. In addition, the normal basic safety precautions for working on motor vehicles must, as a matter of course, be observed.



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50 – Body - front

1 Body - front end

(VRL009972; Edition 01.2017)

1.1 Front end with complementary parts - assembly overview

Front end with complementary parts - remove and install



Note

- ◆ The air conditioning condenser hoses must not be bent.
- ◆ The condenser cannot be suspended by the hoses.

1 - Bolt

- ☐ 2 units
- ☐ Torque: 12 Nm

2 - Front bonnet latch

- ☐ Remove and install
⇒ [page 15](#)

3 - Front end with complementary parts

4 - Bolt

- ☐ 2 units
- ☐ Torque: 8.5 Nm

5 - Protection adhesive tape

- ☐ The adhesive tape adhesion area must be completely free of dirt.
- ☐ Under no circumstances should the self-adhesive surface of the tape be touched.

6 - Front headlight support

7 - Bolt

- ☐ 6 units
- ☐ Torque: 30 Nm

8 - Bolt

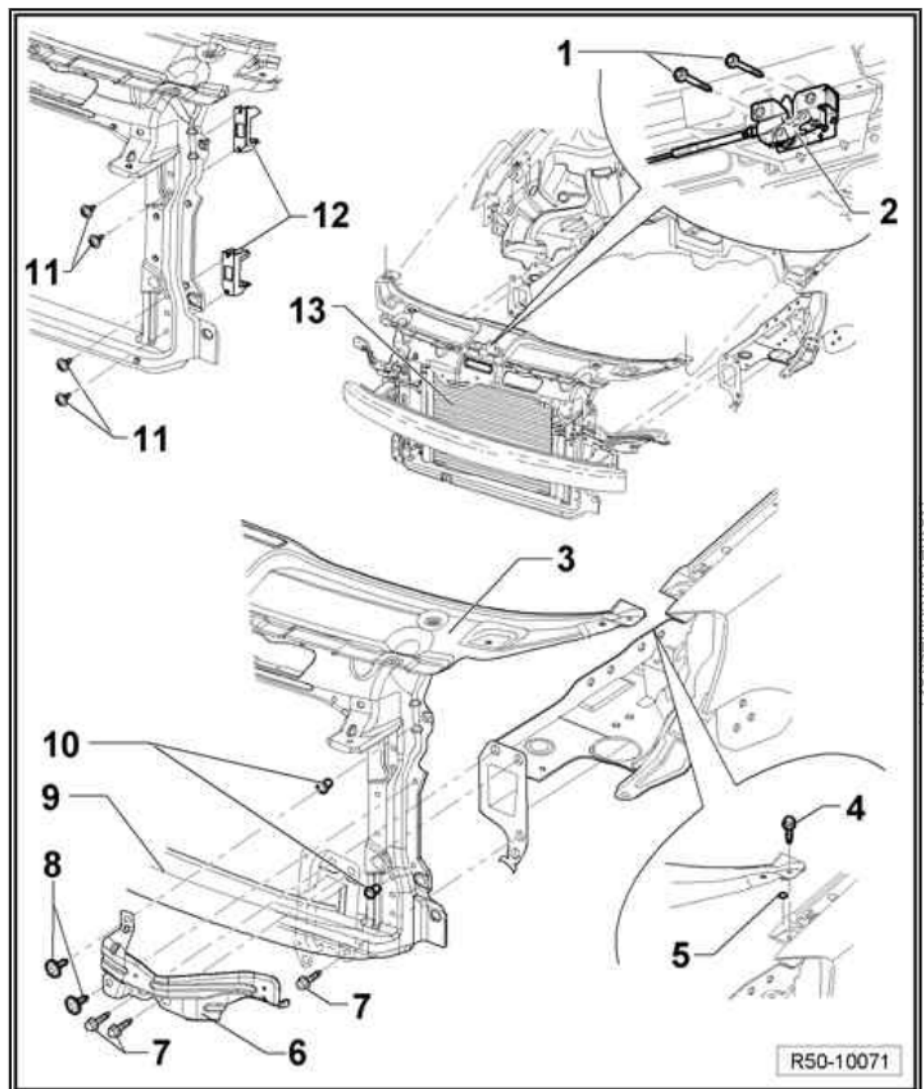
- ☐ 4 units
- ☐ Torque: 8.5 Nm

9 - Front bumper

- ☐ Remove and install
⇒ [page 2](#)

10 - Pop rivet nut

- ☐ To install, use the riveted nut applicator POP NUT - VAG 1765B- or riveted nut applicator POP NUT - EQ 7422-





11 - Radiator mounting support fastening screw

12 - Radiator mounting support

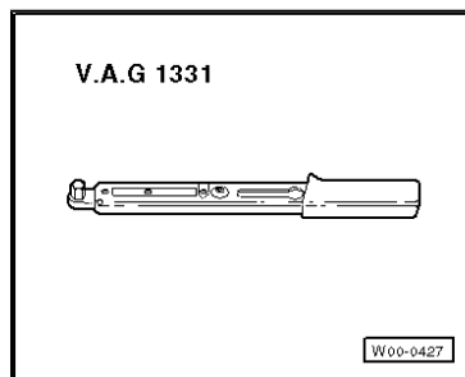
13 - Radiator and condenser

- ☐ Remove from front end ⇒ Heating, ventilation, air conditioning; Rep. gr. 87 ; Air conditioning

1.2 Front end with complementary parts - remove and install

Special tools and workshop equipment required

- ◆ Torque wrench - 5 to 50Nm (1/2" drive) - VAG 1331-



Note

- ◆ *The front panel is a crucial safety part and cannot be repaired / recovered.*
- ◆ *In case of damage, the front panel must be replaced.*

Removal:

- Remove door latch.
- Remove the front protector.
- Remove headlights ⇒ Electrical equipment; Rep. gr. 94 ; Switches, lights, and external lamps .
- Remove the securing bolts -7- of the front bumper -9- and remove it
- Remove the bolts -4-.
- Disengage radiator and condenser set of the ventilation system from radiator mounting supports -11-
- Remove the front panel.

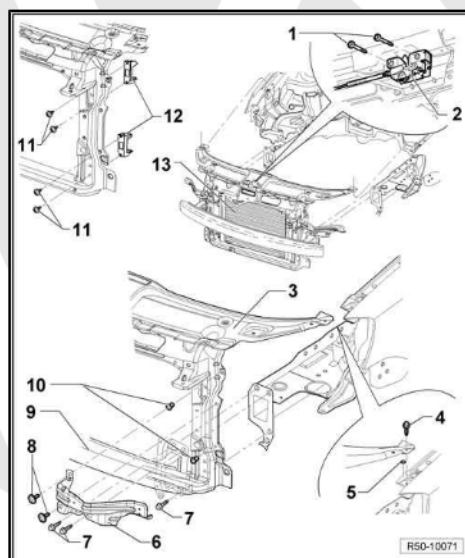
Installation:

Installation is performed in reverse to the removal sequence, observing the following:



Note

Upon installation, centre the lock carrier to the longitudinal members and between the upper section of the wheel housings.

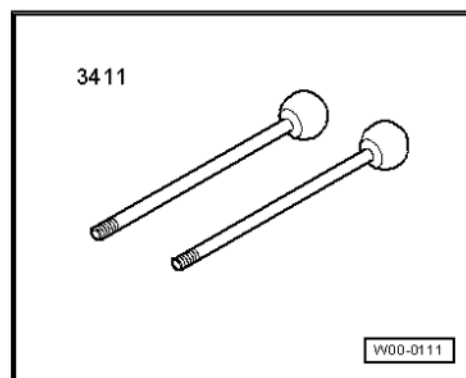




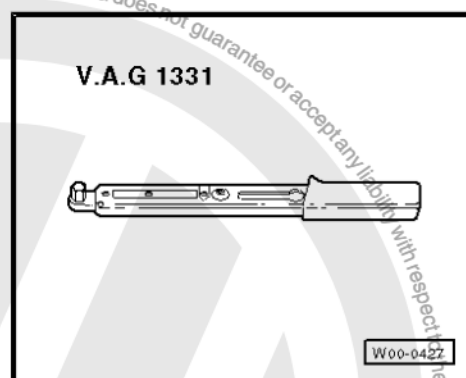
1.3 Front end - service position

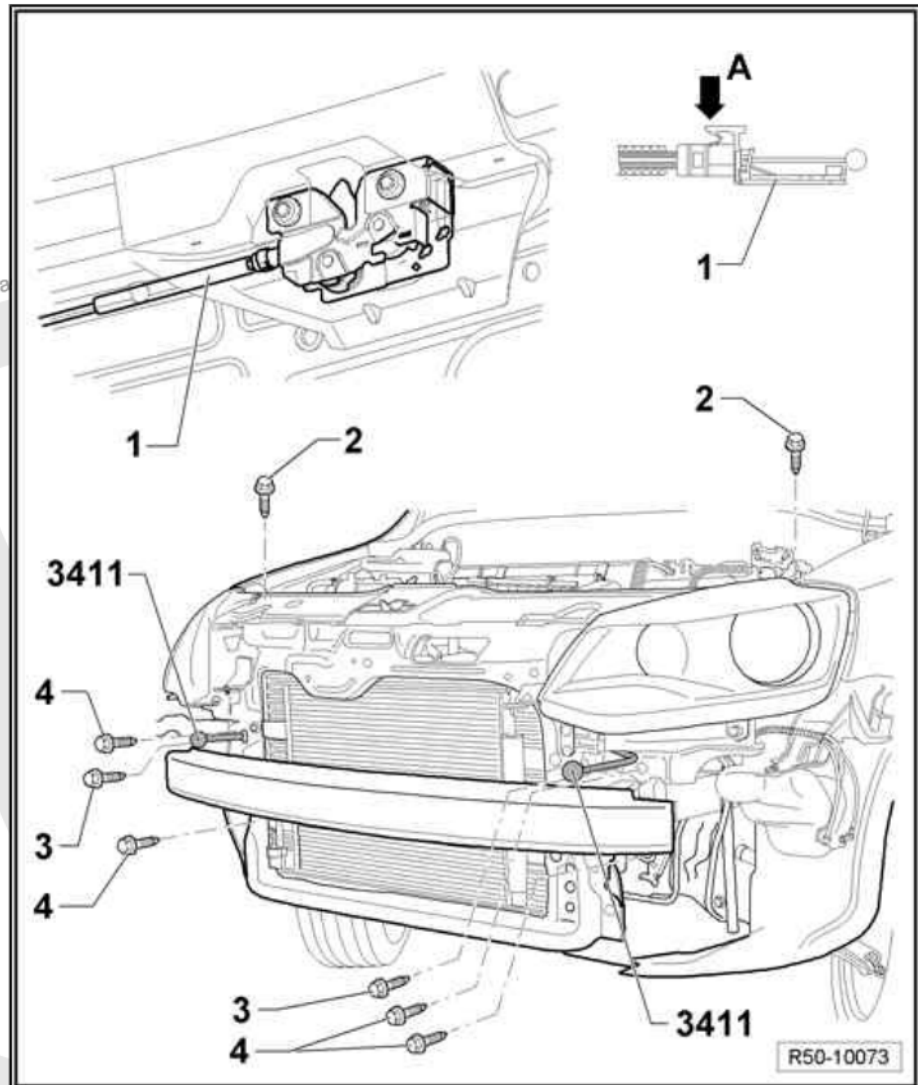
Special tools and workshop equipment required

- ◆ Guide pins - 3411-



Torque wrench - 5 to 50Nm(1/2" drive) - VAG 1331





- Remove the front protector.
- Disengage operating cable from latch -1- by pressing the lock towards -arrow A-, and disengaging it from latch.
- Remove screws -3- and in their places screw guide pins - 3411- in right and left longitudinal member.
- Remove screws -4- and -2-.
- Move right panel forward by sliding it under guide pins - 3411- .

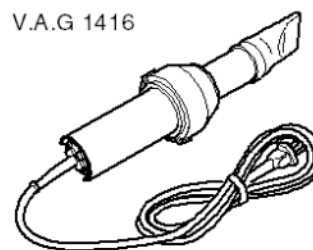
1.4 Front wing - assembly overview

Special tools and workshop equipment required



- ◆ Hot air blower - VAG 1416-

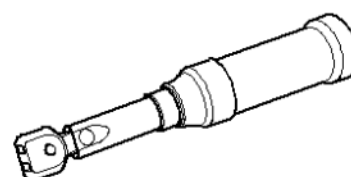
V.A.G 1416



W00-0004

- ◆ Torque wrench 2 to 10 Nm - VAG 1783-

V.A.G 1783



W00-0990



1 - Bolt

- ☐ Torque: 1.5 Nm
- ☐ 1 unit

2 - Pop rivet nut

- ☐ To install, use the Pop rivet nut applier - VAG 1765B- or Pop rivet nut applier - EQ 7422-
- ☐ 5 units

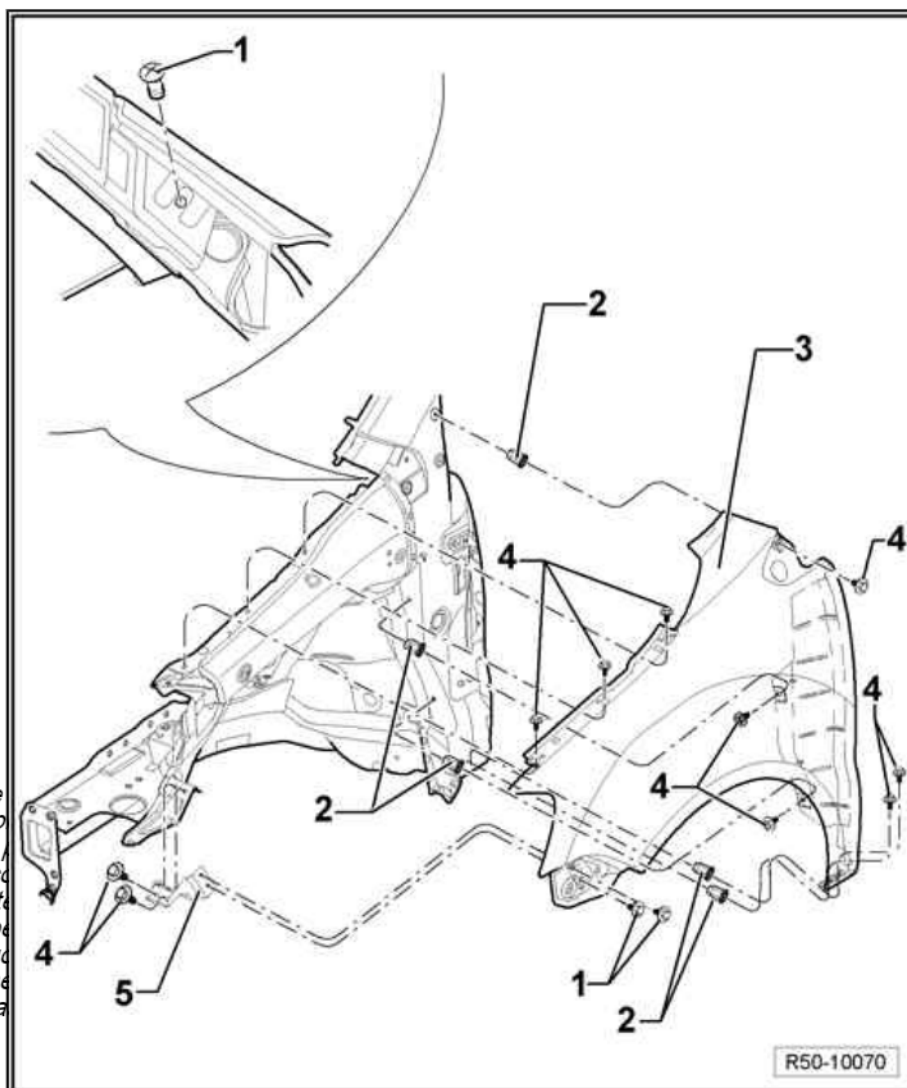
3 - Mudguard

- ☐ Information for removal:
 - Remove the front protector ➔ [page 106](#) .
 - Remove the wheel arch protector ➔ [page 263](#) .
 - If necessary, heat and remove the wing at the A-pillar area with the hot air blower - VAG 1416- .



Note

When installing, before the wing, you must apply zinc-based conductive anticorrosion protection measures - Material - Zinc-based conductive - AKL 381 035 50- to the area of each bumper fastening point.



4 - Bolt

- ☐ Torque: 1.5 Nm
- ☐ 12 units

5 - Mounting bracket

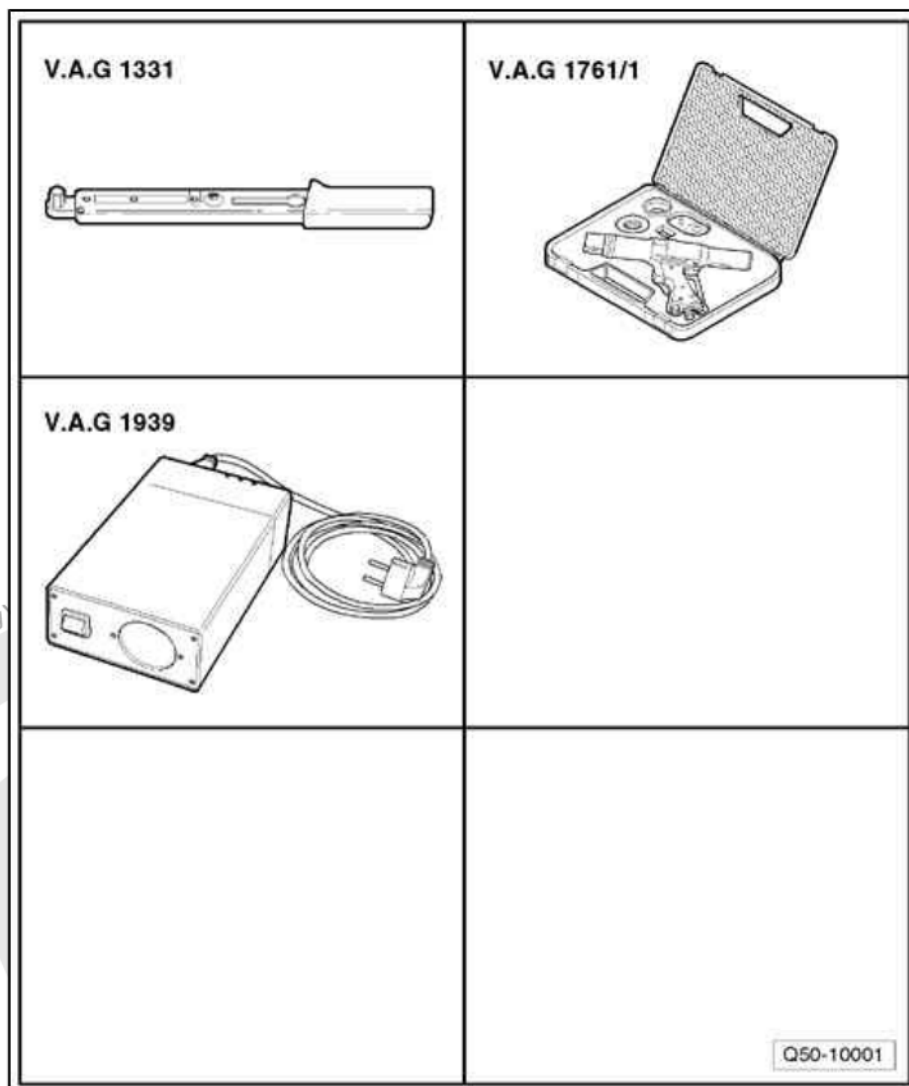
- ☐ Fastened with screws to the wheel arch



2 Bulkhead

2.1 Tools

Special tools and workshop equipment required



- ◆ Torque wrench - 5 to 50Nm (1/2" drive) - VAG 1331-
- ◆ Cartridge heater - VAG 1939A-
- ◆ Pneumatic Adhesive applicator for glued glasses - VAG 1761/1- or Adhesive applicator for glued glasses - VAG 1628-

2.2 Auxiliary materials for Brazilian market



WARNING

- ◆ *When handling chemicals follow the safety instructions ⇒ Chemical Products Manual; Rep. gr. 00*
- ◆ *Assignment of Chemical Materials ⇒ Electronic Parts Catalogue "ETKA"*



- ◆ Glass adhesion kit ⇒ Chemicals Manual;
Rep. gr. 00 ; Chemicals
Manual - List of author-
ized products ^{1, 2, 3}
- ◆ Cleaning solution D 009 401 04 ²

1) Exclusive option for the Brazilian market. The Kit includes (U-400 HV) 310 ml cartridge, primer (primer 5404 A), activator / glass cleaner (primer 5500).

2) Observe the procedural indications in accordance with the manufacturer's pre-
scriptions for packaging disposal

3) Follow the minimum curing time ⇒ [page 9](#) .

2.3 Auxiliary materials for export market



WARNING

- ◆ *When handling chemicals follow the safety instructions ⇒
Chemical Products Manual; Rep. gr. 00*
- ◆ *Assignment of Chemical Materials ⇒ Electronic Parts
Catalogue "ETKA"*

- ◆ 1K Glass adhesive DH 009 100 (300 ml) ^{1, 2, 3}
- ◆ Glass and painting primer D 009 200 02 ¹
- ◆ Cleaning solution D 009 401 04 ¹
- ◆ Primer applicator D 009 500 25

4) Observe the procedural indications in accordance with the manufacturer's pre-
scriptions for packaging disposal

5) Heat up them according to manufacturer instructions Cartridge heater - VAG
1939A-

6) Respect minimum curing time ⇒ [page 9](#)

2.4 Matching table



WARNING

- ◆ *When handling chemicals follow the safety instructions ⇒
Chemical Products Manual; Rep. gr. 00*
- ◆ *Assignment of Chemical Materials ⇒ Electronic Parts
Catalogue "ETKA"*



Note

To help understanding, please find below a comparison table for
materials used in the Brazilian and export markets

Product	Brazilian Market	Export Market
PU Adhesive	U-400 HV	DH 009 100 (300 ml)
Body primer	Primer 5404 A	D 009 200 02



2.5 Engine compartment partition panel - assembly overview



Note

The engine compartment partition panel -1- is also fastened with polyurethane adhesive (PUR) -3-.

1 - Bulkhead

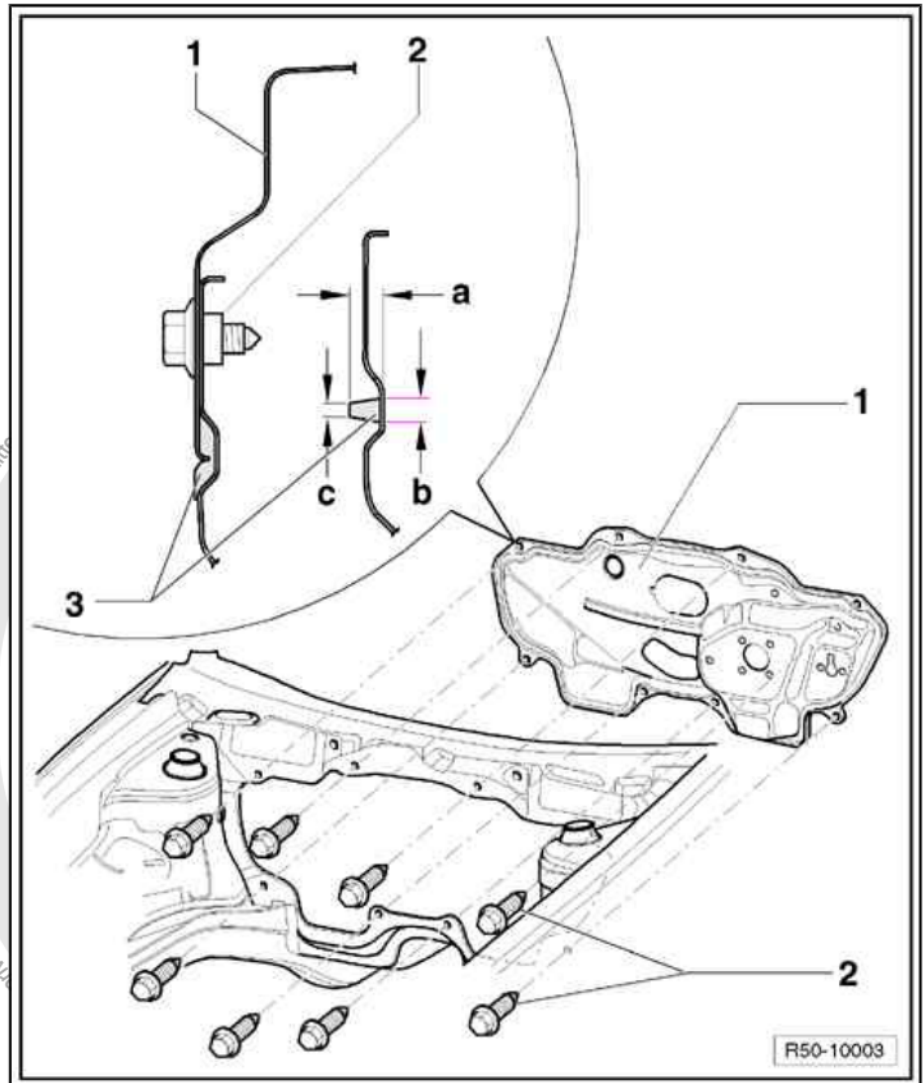
- ☐ Remove:
- After the screws are removed -2-, cut the adhesive cord.

2 - Bolt

- ☐ 8 units
- ☐ Torque: 25 Nm

3 - PUR adhesive

- ☐ Auxiliary materials Brazilian market [⇒ page 7](#)
- ☐ Auxiliary materials for the export market [⇒ page 8](#)
- ☐ cord section: -a- = 11 mm, -b- = 8.5 mm, -c- = 7 mm
- ☐ Minimum curing time [⇒ page 9](#)



2.6 Minimum adhesive drying time

Minimum curing time is the time from panel gluing to vehicle usage. During this time, the vehicle must remain on a flat surface and at room temperature (at least 59 °F).



Note

The vehicle may be delivered to client 3 hours after repair, minimum.



3 Engine compartment upper partition panel

3.1 Engine compartment upper partition panel - assembly overview



Note

The engine compartment upper partition panel -1- is fastened also with polyurethane adhesive (PUR) -3-.

1 - Engine compartment upper partition panel

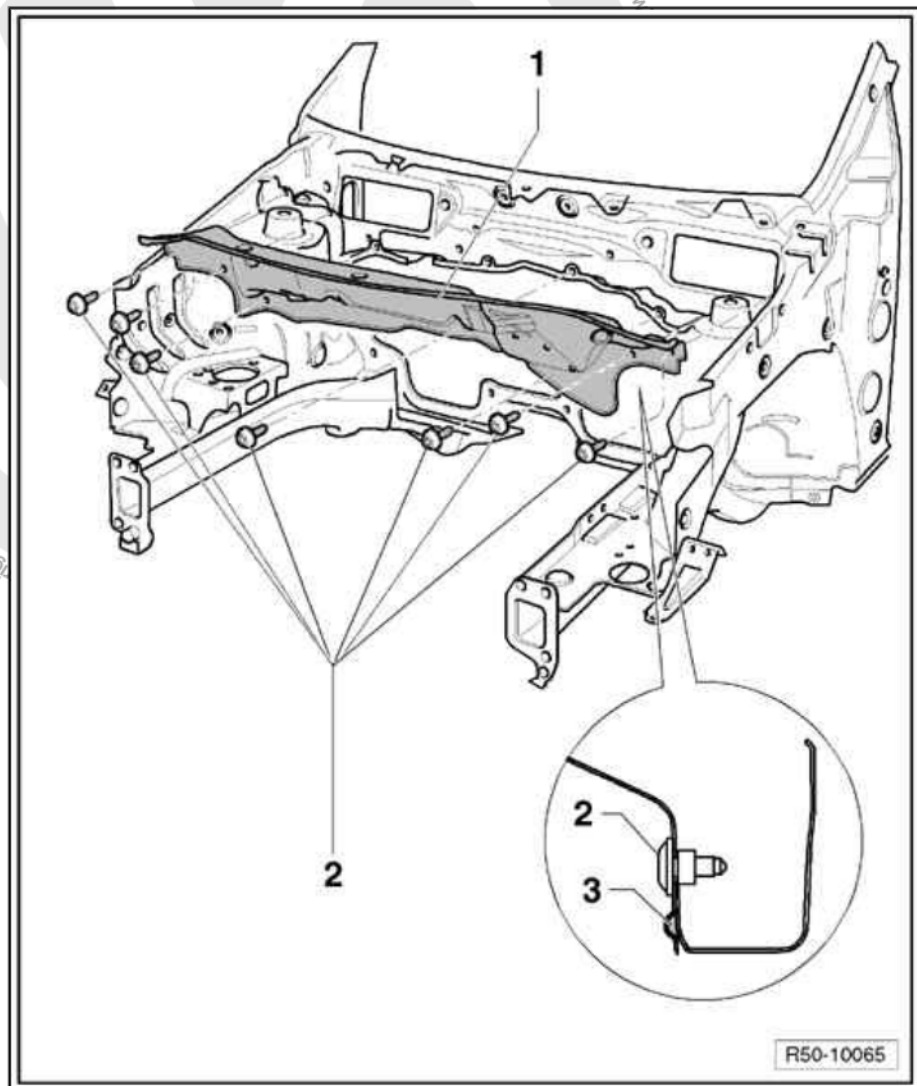
- ☐ Remove:
 - After the screws are removed -2-, cut the adhesive cord.

2 - Bolt

- ☐ 8 units
- ☐ Torque: 25 Nm

3 - PUR adhesive

- ☐ Auxiliary materials Brazilian market ⇒ [page 7](#)
- ☐ Auxiliary materials for the export market ⇒ [page 8](#)
- ☐ Minimum curing time ⇒ [page 9](#)





55 – Bonnet, rear lid

1 Bonnet

1.1 Bonnet - assembly overview

1 - Front bonnet side packing

2 - Bonnet supporting rod

3 - Bushing

4 - Expansion pin

5 - Fastening clip

- ☐ For bonnet supporting rod

6 - Protection adhesive tape

- ☐ Under no circumstances should the self-adhesive surface of the tape be touched.

- ☐ Clean the tape application area with adhesive remover - D 002 000 A2- and then apply cleaning solution - D 009 401 04-

7 - Adjustment buffer

- ☐ The bonnet can be adjusted in the height in relation to the wing by threading or unthreading it

8 - Bolt

- ☐ 2 pieces per hinge
- ☐ Torque: 24 Nm

9 - Hinge

10 - Bolt

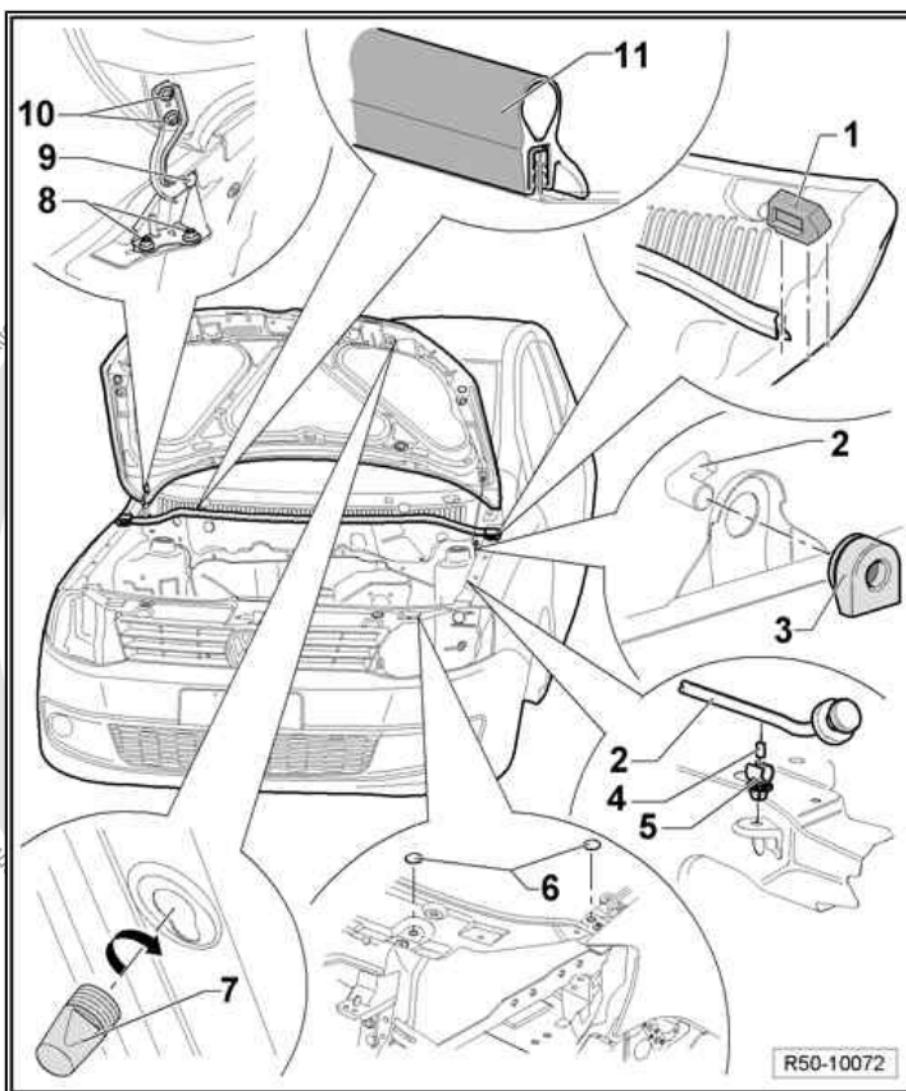
- ☐ 2 pieces per hinge
- ☐ Torque: 24 Nm

11 - Bonnet trim

- ☐ Fitted onto the flange

12 - Bonnet

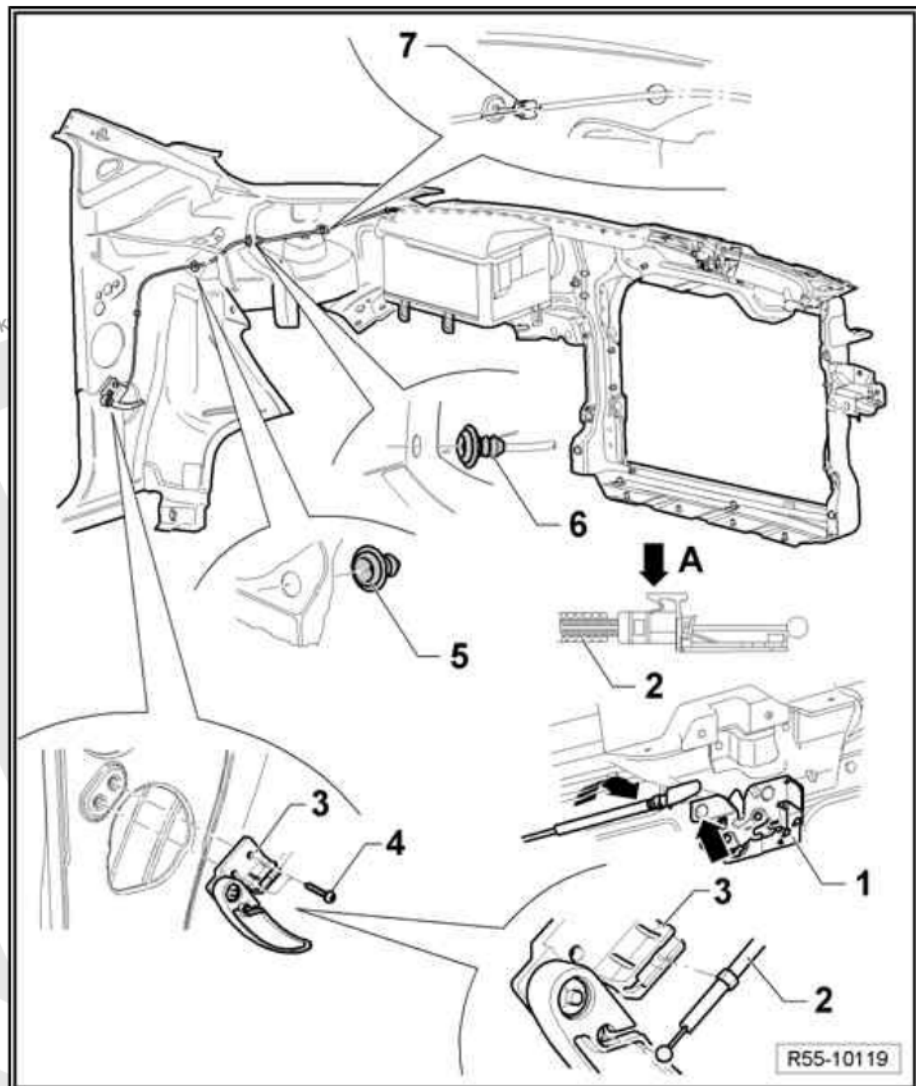
- ☐ Remove:
 - Remove pipes for windscreen washer and nozzles.
 - Loose screws -9- of front bonnet, and remove the bonnet.
- ☐ Adjust ⇒ [page 14](#)





1.2 Operating cable - assembly overview

- 1 - Front bonnet latch
 - ☐ Assembly overview
⇒ [page 13](#)
 - ☐ Remove and install
⇒ [page 15](#)
- 2 - Operating cable
 - ☐ Remove and install
⇒ [page 13](#)
- 3 - Activation lever
 - ☐ With support
- 4 - Bolt
 - ☐ Torque: 1.5 Nm
- 5 - Sealing eyelet
 - ☐ From water deflector panel to the passenger compartment.
- 6 - Sealing bellows
 - ☐ From engine compartment to water deflector panel.
- 7 - Operating cable fastening clamp
 - ☐ 2 units

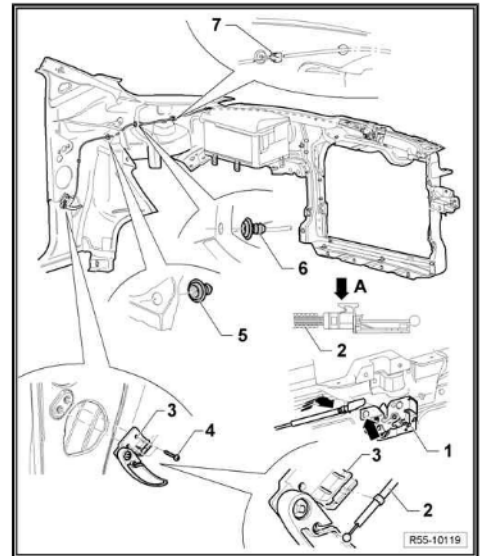




1.3 Operating cable - remove and install

Removal:

- Disengage the Onboard electric supply network control unit - J519- and its support. Disengage relay plate and put it aside; afterwards, remove the three screws fastening the support to the relay plate.
- Remove lower windscreen lining.
- Press cable lock -2- towards -arrow A- and disengage cable -2- from the ball housing in the lower latch of front bonnet -1-.
- Disengage operating cable -2- from operating cable-3- lever housing.
- Remove fastening screws -4- from actuating lever and disengage actuating lever from A-pillar.
- Pull the cable by the engine compartment side. Disengage eyelet cable -5- and -6-. Disengage clip cable -7-.
- Pull operating cable -2- in direction of engine compartment.



Installation:

Install is performed in the reverse sequence, observing the following:



Note

Check correct position of cable pass-through eyelet -5- and -6- to prevent leaks.

- Check whether the latch activation and the opening mechanism operation is OK before closing the bonnet.

1.4 Front bonnet latch and stop - assembly overview



WARNING

- ◆ *When handling chemicals follow the safety instructions ⇒ Chemical Products Manual; Rep. gr. 00*
- ◆ *Assignment of Chemical Materials ⇒ Electronic Parts Catalogue "ETKA"*



1 - Front bonnet latch safety hook

- ☐ Align with buffer handle.

2 - Front bonnet buffer handle

3 - Front bonnet buffer

- ☐ Remove and install
⇒ [page 17](#)

4 - Front bonnet latch

- ☐ Remove and install
⇒ [page 15](#)

5 - Bolt

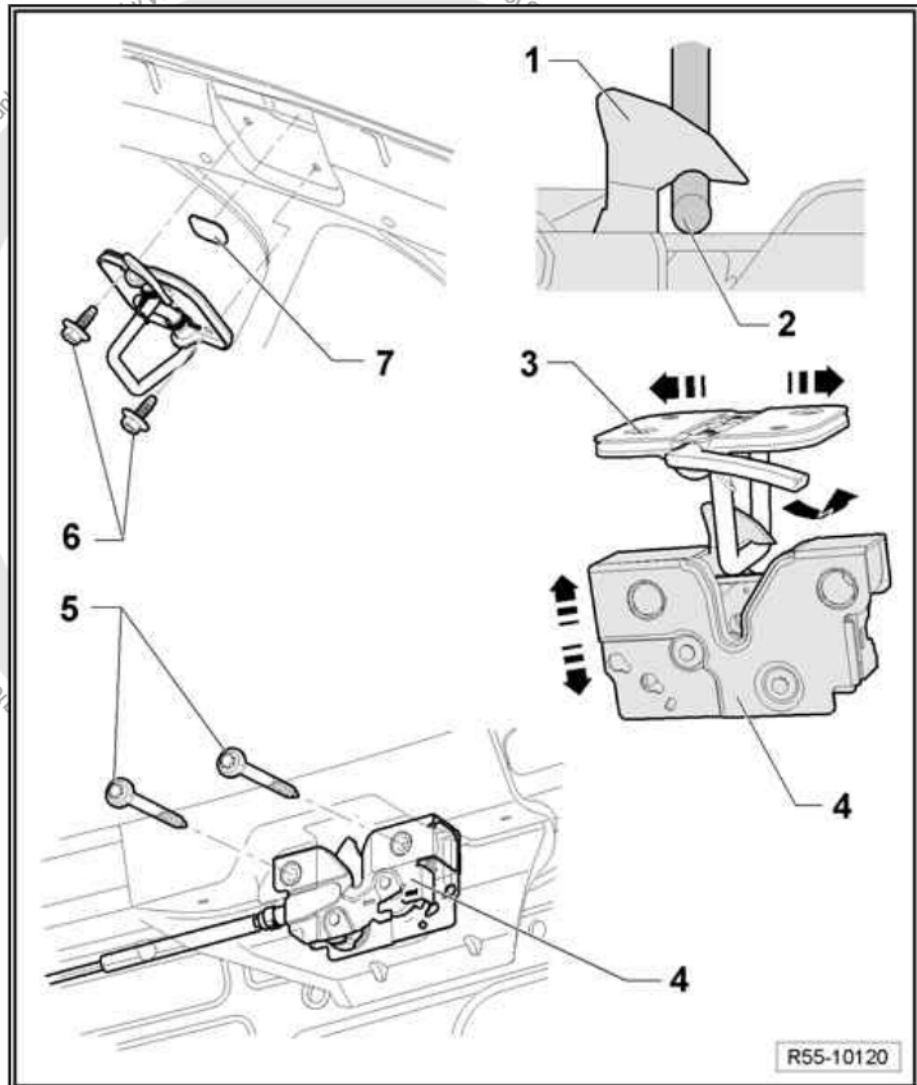
- ☐ Torque: 12 Nm

6 - Bolt

- ☐ Torque: 12 Nm

7 - Protection adhesive tape

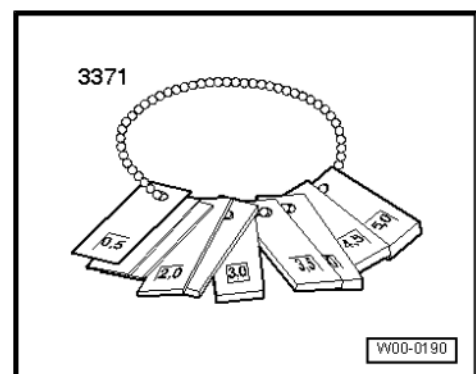
- ☐ Under no circumstances should the self-adhesive surface of the tape be touched.
- ☐ Clean the tape application area with adhesive remover - D 002 000 A2- and then apply cleaning solution - D 009 401 04-

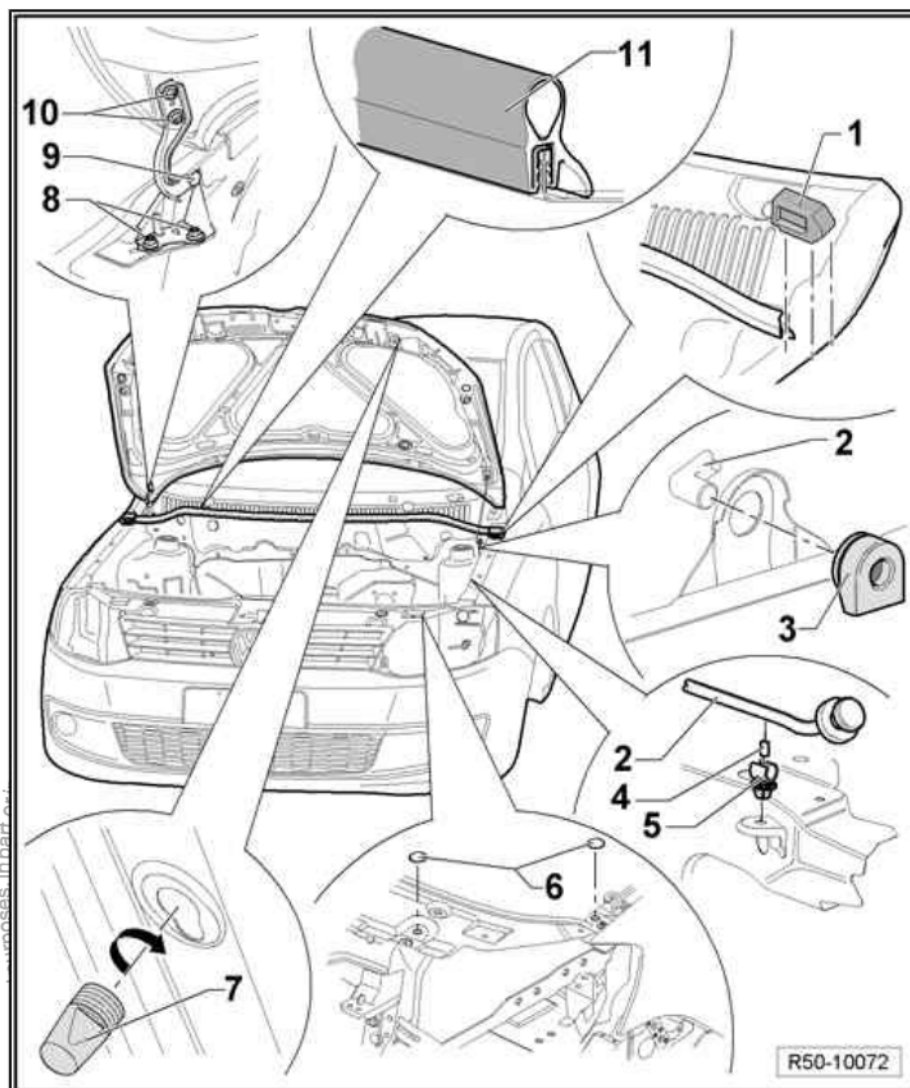


1.5 Bonnet - adjust

Special tools and workshop equipment required

- ◆ Adjustment gauge - 3371-





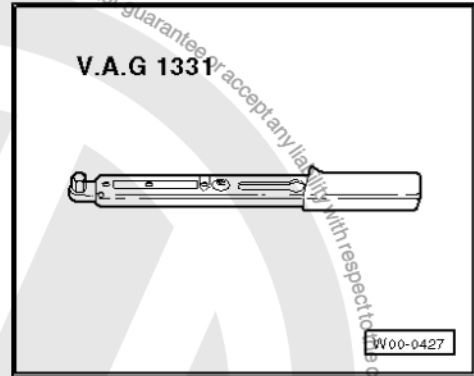
- The bonnet can be aligned between the wings by moving the bonnet hinges -9- in the elongated holes.
- Loosen the nuts -10-.
- Through the adjustment stops -7-, the bonnet can be adjusted for height in respect to the wing panels.
- Clearance dimensions ⇒ Body Repairs; Rep. gr. 00 ; Technical data - Body clearance dimensions .
- After the assembly or adjustment works, the following measures for protection against corrosion in hinges and nuts must be taken.

1.6 Bonnet latch - remove and install

Special tools and workshop equipment required



- ◆ Torque wrench - 5 to 50 Nm (1/2" drive) - VAG 1331-



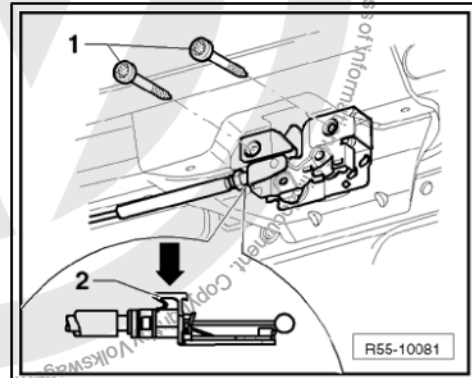
Removal:

- Press cable lock -2- and disengage the operating cable from latch.
- Remove screws -1- and remove the latch.

Installation:

Installation is performed in reverse to the removal sequence, observing the following:

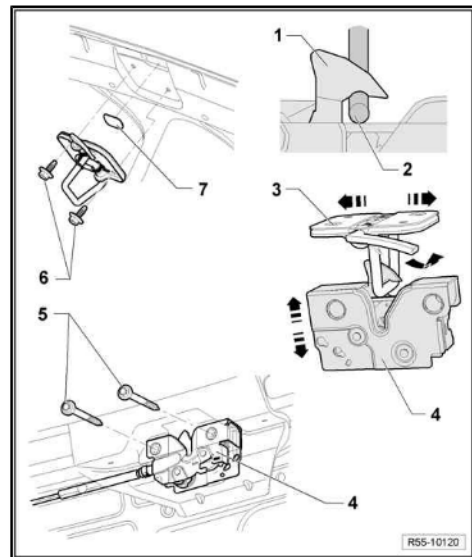
- Install operating cable in the latch.
- Position the latch and install screws -5-. Do not tighten the screws.
- Adjust the latch by the elongated holes.



Note

Align buffer handle centre -1- with latch safety hook centre -2-.

- Check clearance dimensions ⇒ Body Repairs; Rep. gr. 00 ; Technical data - Body clearance dimensions .
- Definitely tighten the screws.
- ◆ Torque of screws -5-. 12 Nm.



1.7 Bonnet hinge - remove and install

Special tools and workshop equipment required



- ◆ Torque wrench - 5 to 50 Nm (1/2" drive) - VAG 1331-

V.A.G 1331



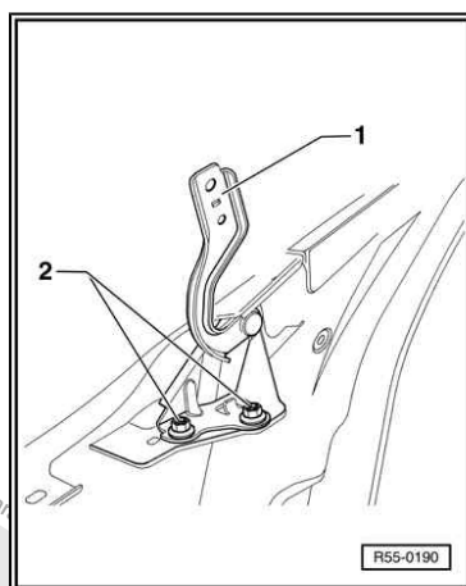
W00-0427

Removal:

- Remove bonnet ➔ [page 11](#) .
- Remove the screws -2- for fastening the hinge -1-.

Installation:

- Install the hinge -1-.
- Torque of screws -2-. Torque: 24Nm.
- Install bonnet.



1.8 Bonnet striker - remove and install

Special tools and workshop equipment required

- ◆ Torque wrench - 5 to 50 Nm (1/2" drive) - VAG 1331-

V.A.G 1331



W00-0427



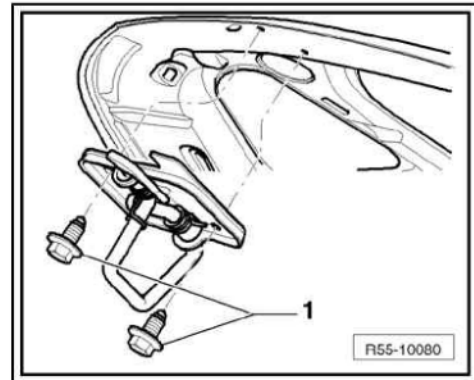
Removal:

- Remove the bolts -1-.

Installation:

Installation is performed in reverse to the removal sequence, observing the following:

- Position buffer and install screws -6-. Do not tighten the screws.

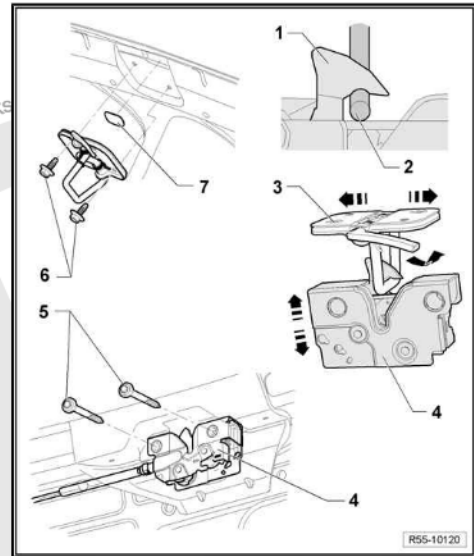


- Adjust buffer through elongated holes.
- Check clearance dimensions ⇒ Body Repairs; Rep. gr. 00 ; Technical data - Body clearance dimensions .
- Definitely tighten the screws.
- ♦ Torque of screws -6-. Torque: 12 Nm.



Note

Align buffer handle centre -1- with latch safety hook centre -2-.

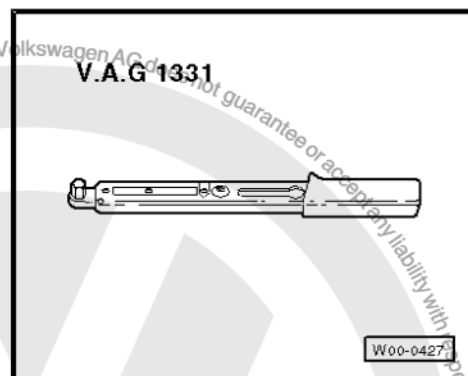




2 Rear lid (Fox)

Special tools and workshop equipment required

- ◆ Torque wrench - 5 to 50 Nm (1/2" drive) - VAG 1331-



2.1 Rear lid - assembly overview



WARNING

- ◆ *When handling chemicals follow the safety instructions ⇒ Chemical Products Manual; Rep. gr. 00*
- ◆ *Assignment of Chemical Materials ⇒ Electronic Parts Catalogue "ETKA"*



1 - Draining membrane

2 - Adjustment buffer

- Adjust ⇒ [page 24](#)

3 - Rear lid shock absorber

- Remove and install ⇒ [page 21](#)
- Replace ⇒ [page 21](#)
- Lubricate eyelets with lubricating grease - G 052 745 A3- .

4 - Threaded pin

- from chassis 94065214
- Torque: 21 Nm

5 - Bolt

- 2 units
- Torque: 8 Nm

6 - Rear lid buffer

- Remove rear panel lining for access ⇒ General body repairs, interior; Rep. gr. 70 ; Lining / insulation
- Adjust: through elongated holes
- Clearance dimensions ⇒ Body Repairs; Rep. gr. 00 ; Technical data - Body clearance dimensions .

7 - Rear lid trim

- Remove and install ⇒ [page 21](#)

8 - Hexagonal nut

- Torque: 24 Nm

9 - Bolt

- Torque: 10 Nm

10 - Hinge

- Remove and install ⇒ [page 23](#)

11 - Additional brake light

- Removing and installing ⇒ Electrical system; Rep. gr. 94 ; Switches, lights, and external lamps

12 - Rear lid

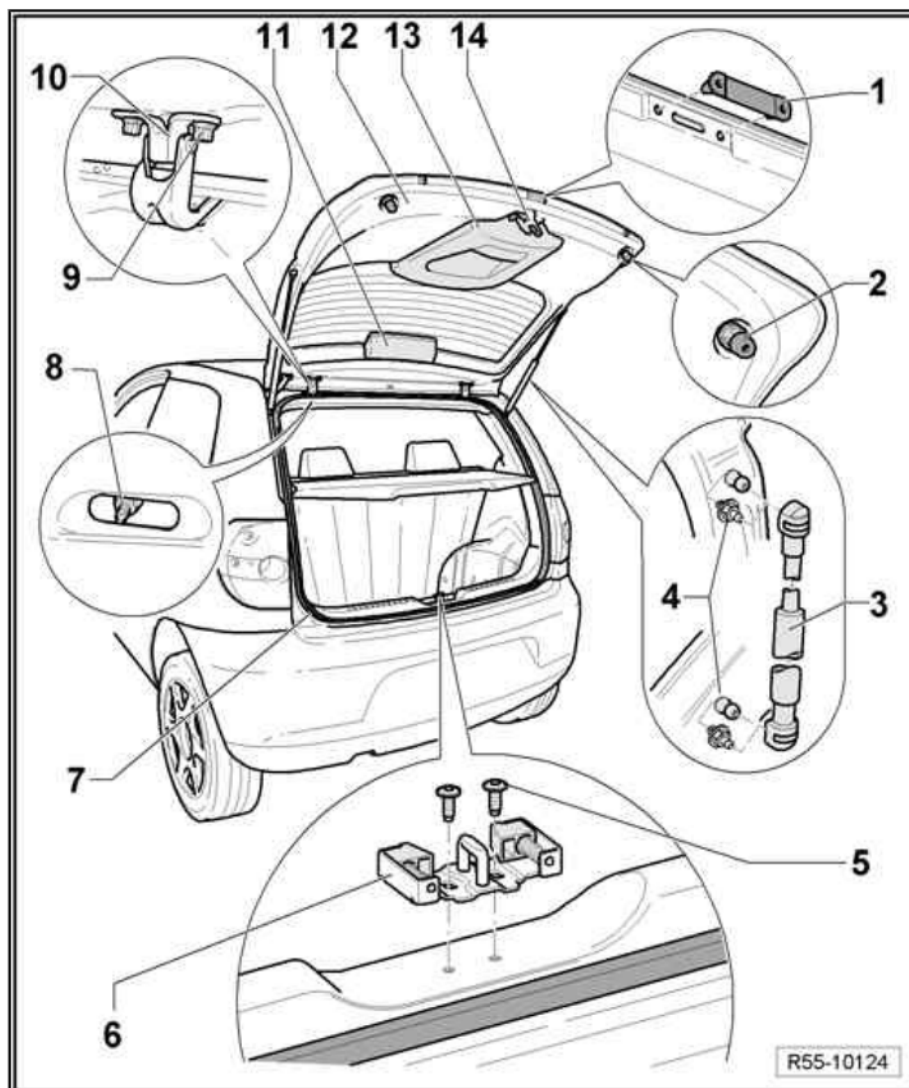
- Remove and install ⇒ [page 23](#)
- Adjust ⇒ [page 24](#)
- Clearance dimensions ⇒ Body Repairs; Rep. gr. 00 ; Technical data - Body clearance dimensions.

13 - Lining

- remove and install ⇒ General body repairs, interior; Rep. gr. 70 ; Linings / insulations

14 - Rear door latch

- Remove and install ⇒ [page 25](#)





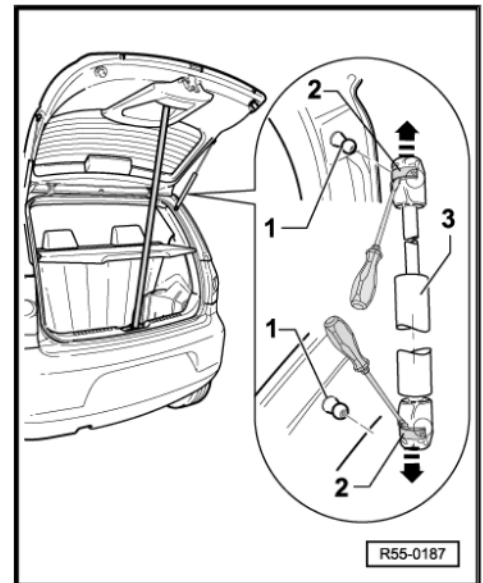
2.2 Rear door shock absorber - remove and install

- Support the rear lid.
- Place a small screwdriver underneath the spring clip -2-.
- Raise the clip -2- enough to allow the clip to move over the ball joint housing in the -direction of arrow-.
- Pull the gas shock absorber -3- from the joint pins -1-.
- After removing the shock absorber -1-, move the clip -2- back immediately.



Note

Be careful when installing the shock absorber. The clip -2- cannot be completely disengaged from the ball joint housing; otherwise, it will be damaged. If the shock absorber fastening is damaged, there is the risk of accident or personal injury.



2.3 Rear door shock absorber - replace

- Fasten the gas shock absorber to the vise, in area $x = 50$ mm.



DANGER!

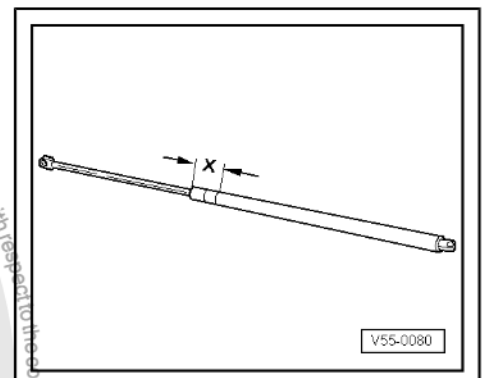
The fastening can only be performed in this area, otherwise there is risk of accident!

- Saw the gas shock absorber cylinder on the first third of its full length, from the reference corner on the plunger rod side.



Note

- ◆ Wear safety goggles when cutting with the saw.
- ◆ The cutting area must be covered with a cleaning cloth.
- ◆ Oil and the cleaning cloth must be duly discarded.



2.4 Rear lid trim - remove and install



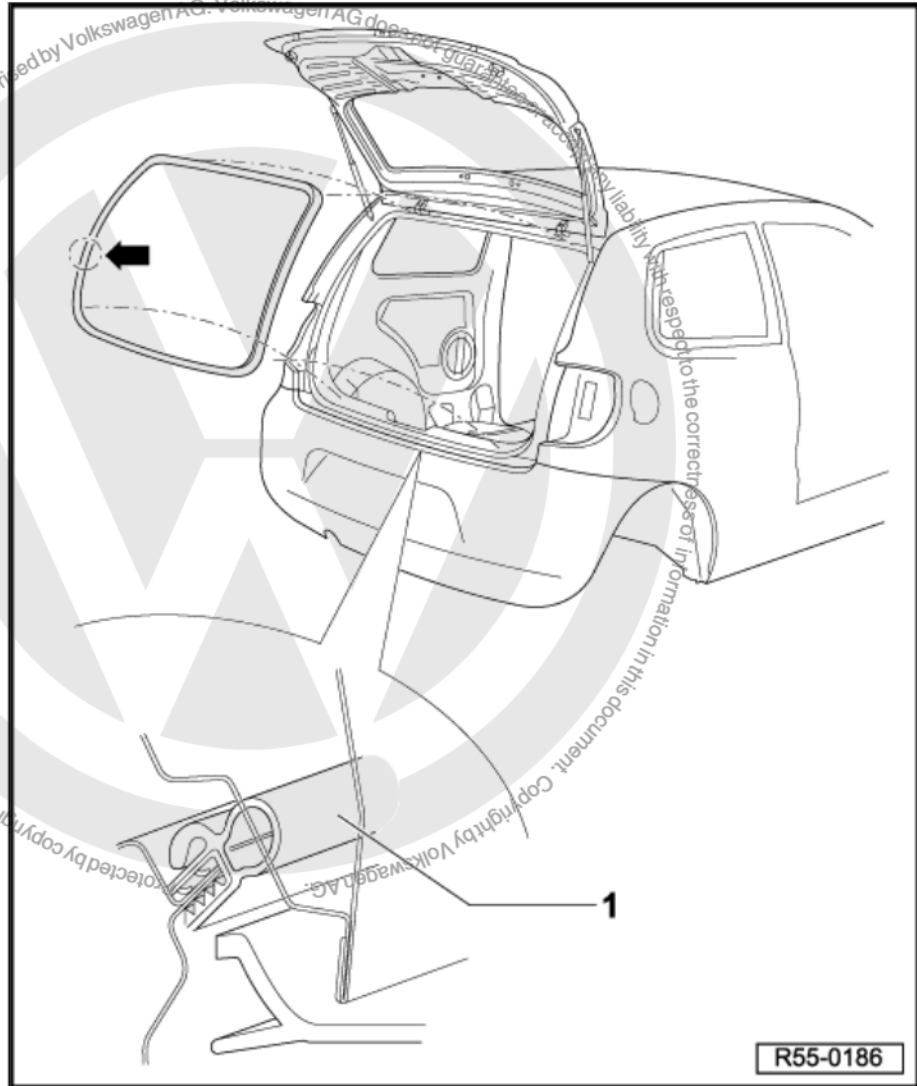
Note

- ◆ For partially removed packing, it is necessary to press packing sides before assembly.
- ◆ New part installation shall be carried out by slightly tapping with a rubber hammer.



1 - Sealing trim

- Start with the flange next to the left rear light to install packing -arrow-.





2.5 Rear lid - remove and install

Removal:

- Open rear door -1-.
- Remove the rear lid lining ⇒ General body repairs, interior; Rep. gr. 70 ; Lining / insulation .
- Disengage electric connections and the rear window washer hose.
- Remove electric harnesses from door.
- Release the bolts -4- from the hinge -5-.

For the items below, you will need the help of an assistant.

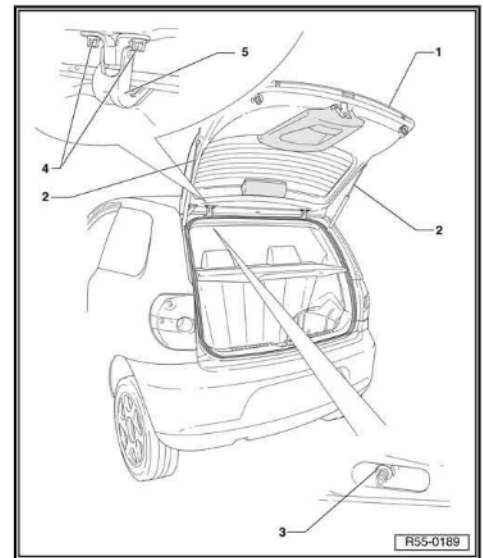
- Remove the rear door shock absorber rod -2- from the rear door -1-.
- Remove the screws -4- and remove the lid

Installation:

Installation is performed in reverse to the removal sequence, observing the following:

Installation is performed in the reverse sequence of the removal.

- Torque of the bolts: 10 Nm
- Adjust the cover ⇒ [page 24](#) .
- Before closing the rear lid, check rear door locking device motor operation.



2.6 Rear lid hinge - remove and install

Removal:

- Remove rear door -1-.





- Remove the pillar C lining ⇒ Body - Internal assembly works; Rep. gr. 70 ; Lining / insulation .
- Lower the roof lining ⇒ General body repairs, interior; Rep. gr. 70 ; Lining / insulation
- Remove the nut -3- that fastens the hinge to the rear roof cross member.

Installation:

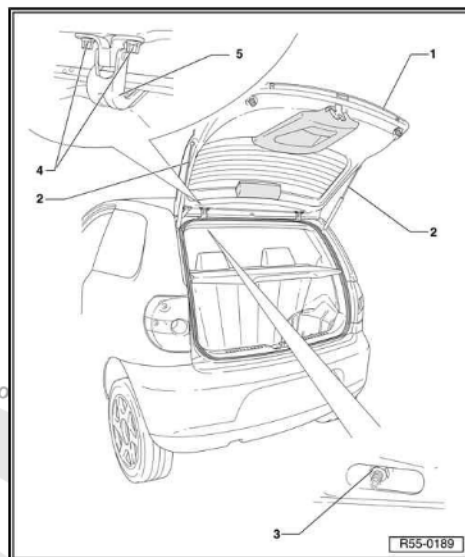
Installation is performed in reverse to the removal sequence, observing the following:



Note

Apply tightening torque on the nut -3- after installing the rear door -1-.

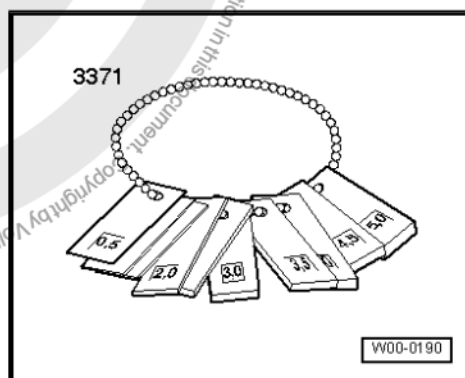
- Install the hinge -5- and tighten the nut -3- with a torque of: 24 Nm.
- Install the rear lid.
- Tighten the nut -3- again to tightening torque of 24 Nm.
- Install the C-pillar lining ⇒ General body repairs, interior; Rep. gr. 70 ; Lining / insulation
- Install the roof lining ⇒ General body repairs, interior; Rep. gr. 70 ; Lining / insulation



2.7 Rear lid - adjust

Special tools and workshop equipment required

- ♦ Adjustment gauge - 3371-



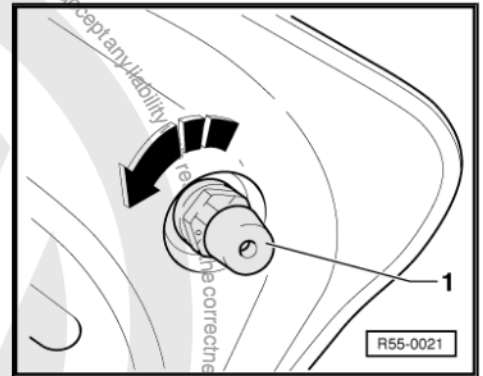
Note

- ♦ *The rear lid is properly adjusted when its clearance is the same at all points when it is closed, not being too much inward or outward, and when contours match.*
- ♦ *Check clearance dimensions ⇒ Body Repairs; Rep. gr. 00 ; Technical data - Body clearance dimensions .*
- ♦ *The vehicle wheels must be on the floor so that the adjustment can be made.*



Stop adjustment

- Turn the adjustment buffer 90° with a ring spanner (SW 24) and remove it.
- Remove rubber buffer -1- from adjustment buffer and loosen fastening screw (3-mm internal hexagonal) until hitch sliding mechanism can be removed.

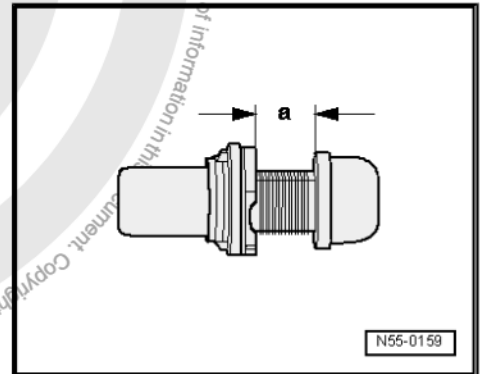


- Pull hitch sliding mechanism out of body and adjust with dimension $a = 12.5$ mm.

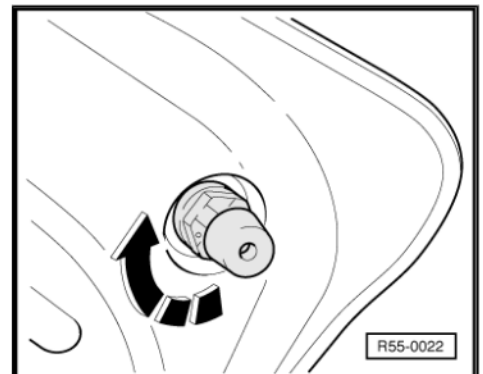


Note

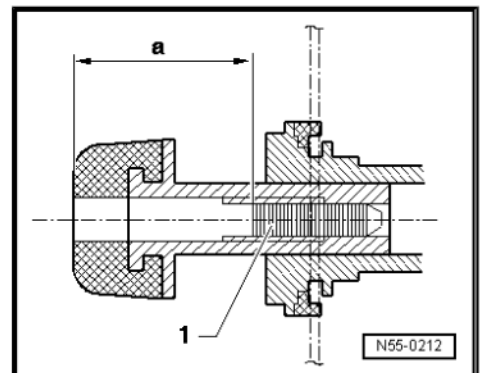
A new adjustment stop is already adjusted on a 12.5-mm distance.



- Place adjustment buffer and assemble in the sectional hole with a 90° turn.
- Close rear door until preliminary lock by slightly pressing its central section.
- Open the rear lid again.



- Screw fastening screw -1- to $a = 20.5$ mm.
- Check adjustment.

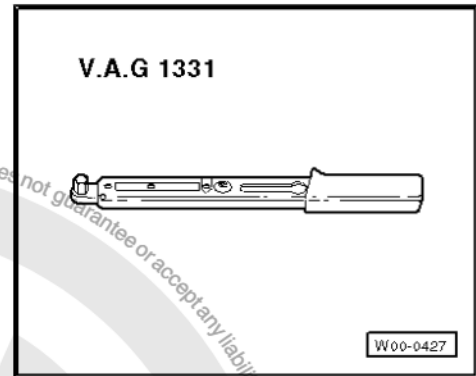


2.8 Rear lid lock - remove and install

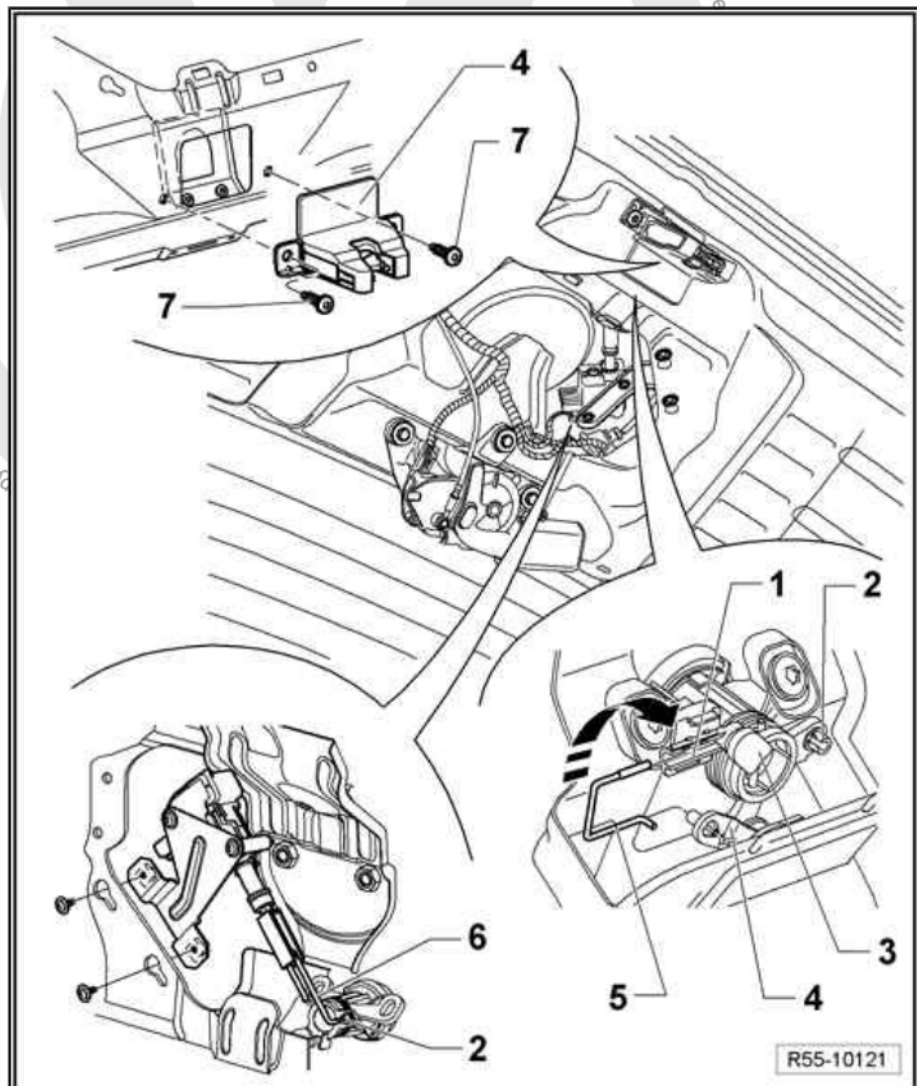
Special tools and workshop equipment required



- ◆ Torque wrench - 5 to 50 Nm (1/2" drive) - VAG 1331-



- 1 - Operating clip
- 2 - Bushing
 - ☐ Replace, as required
- 3 - Latch cylinder
 - ☐ Disassemble
 - ☐ Remove and install
⇒ [page 29](#)
- 4 - Rear door latch
 - ☐ Remove
 - Remove the rear lid lining ⇒ General body repairs, interior; Rep. gr. 70 ; Lining / insulation
 - Disengage rod -6- from bushing -2-.
 - Unlock operating clip -1- and disengage the latch selector rod -5-.
 - Disconnect luggage compartment lighting switch - F5- harness.
 - Remove screws -7- and remove the latch.
 - ☐ Install
 - Installation is performed in the reverse sequence of the removal.
- 5 - Latch selector rod
- 6 - Operating rod for Rear lid release motor - V139-
- 7 - Bolt
 - ☐ Torque: 8 Nm



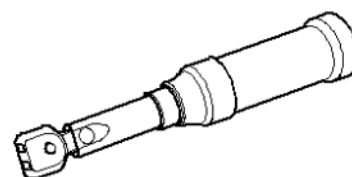
2.9 Rear lid unlocking motor -V139- - remove and install

Special tools and workshop equipment required



- ◆ Torque wrench 2 to 10 Nm - VAG 1783-

V.A.G 1783



W00-0990

1 - Rear lid unlocking motor - V139-

- ☐ Remove:
 - Remove the rear lid lining ⇒ General body repairs, interior; Rep. gr. 70 ; Lining / insulation .
 - Disconnect the connector -7-.
 - Disengage rod -2- from bushing -4-.
 - Loosen the screws -6-.
 - Move support with motor -5- over door plate elongated holes, and remove it.
- ☐ Install:
 - Installation is performed in the reverse sequence of the removal.

2 - Operating rod

3 - Latch cylinder

4 - Bushing

- ☐ Replace, as required

5 - Engine support

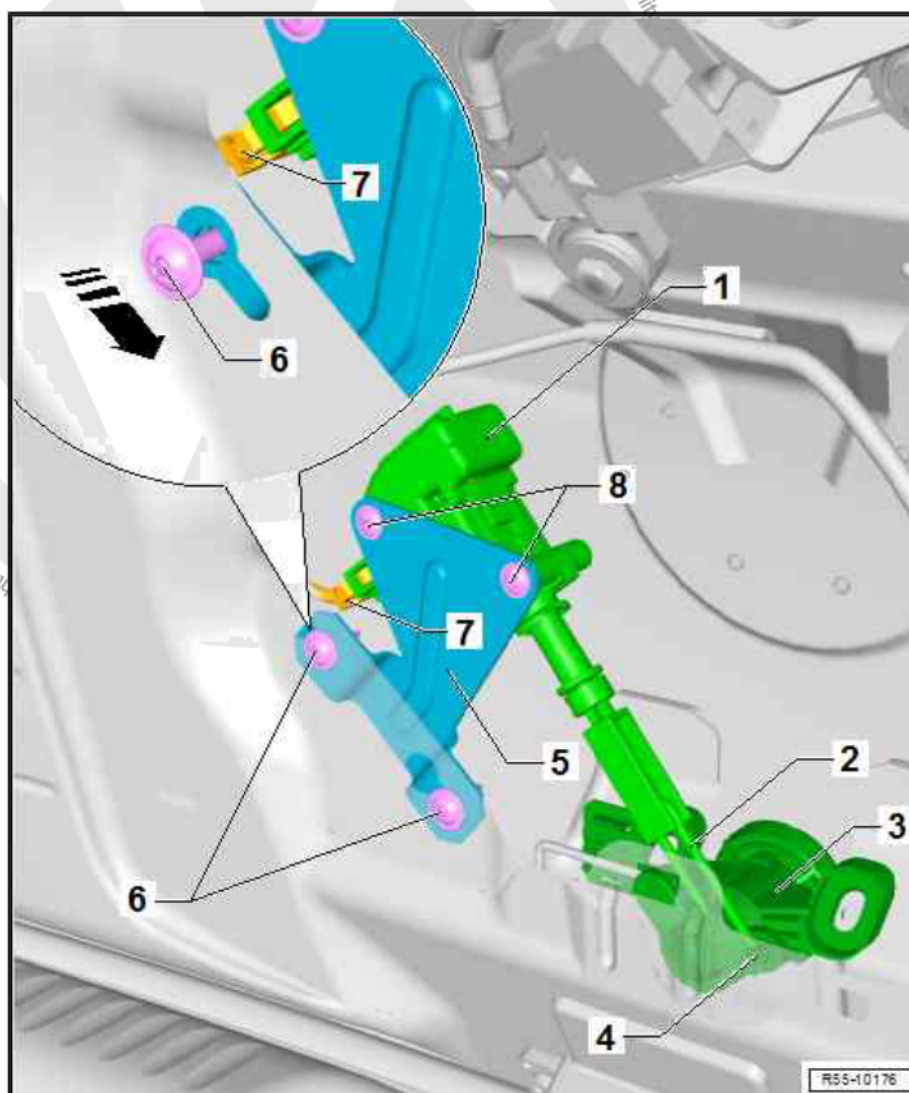
6 - Bolts

- ☐ 2 units
- ☐ Torque: 8.2 Nm

7 - Connector

8 - Bolts

- ☐ 2 units
- ☐ Torque: 1.5 Nm



R55-10176



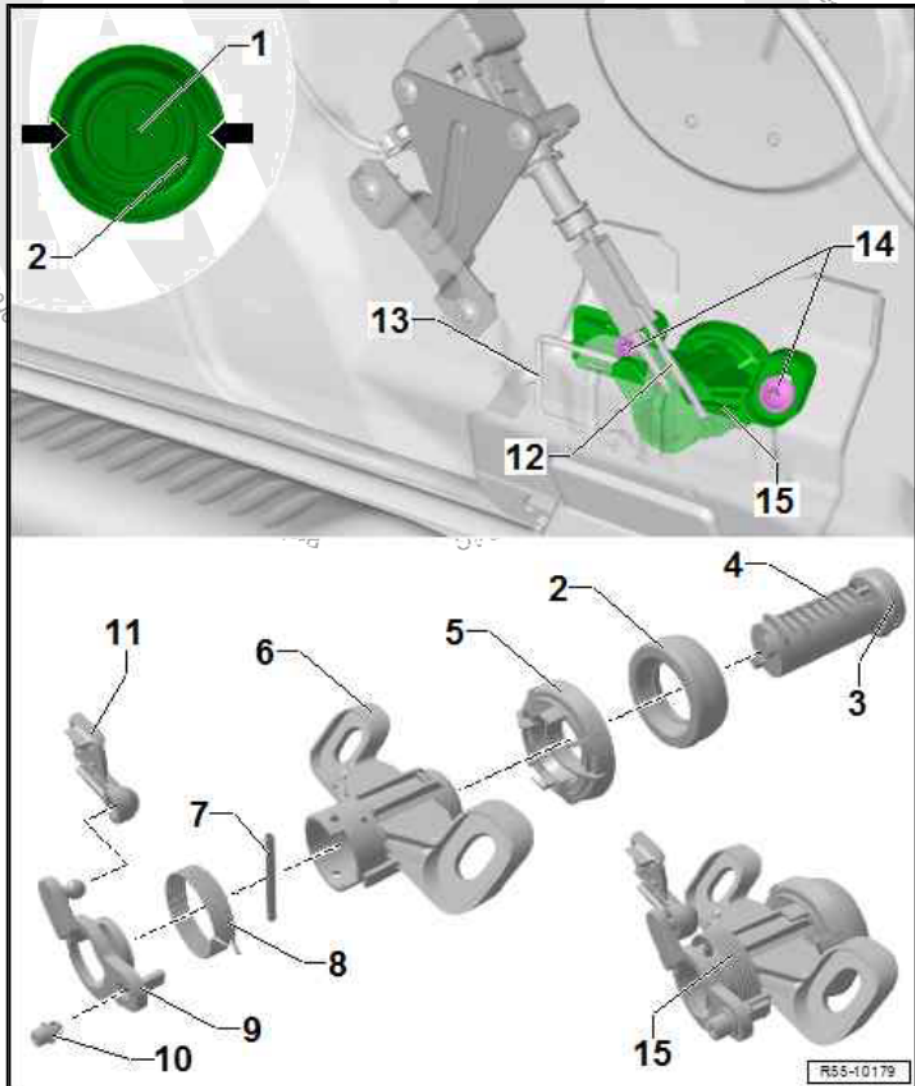
2.10 Latch cylinder - assembly overview



WARNING

- ◆ When handling chemicals follow the safety instructions ⇒ *Chemical Products Manual; Rep. gr. 00*
- ◆ Assignment of Chemical Materials ⇒ *Electronic Parts Catalogue "ETKA"*

- 1 - Key passage slot in cylinder
- 2 - Sealing ring
 - Fastened to the support -5-
- 3 - Cylinder sealing ring
- 4 - Cylinder
 - Lubricate with special grease - G 000 450 02-
- 5 - Sealing ring support
- 6 - Cylinder housing
- 7 - Elastic pin
- 8 - Return spring
- 9 - Actuator
 - Locking system.
 - fastened by the elastic pin -7-.
- 10 - Clip
- 11 - Bushing
- 12 - Operating rod for Rear lid release motor - V139-
- 13 - Latch selector rod
- 14 - Bolt
 - 2 units
 - Torque: 8 Nm
- 15 - Assembled cylinder set





2.11 Latch cylinder - remove and install

Torque wrench 2 to 10 Nm - VAG 1783-

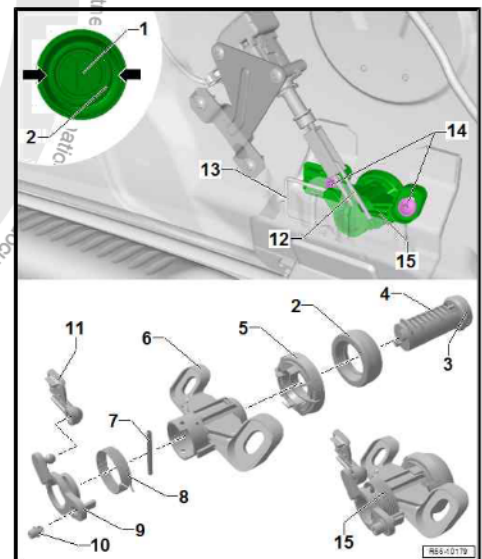
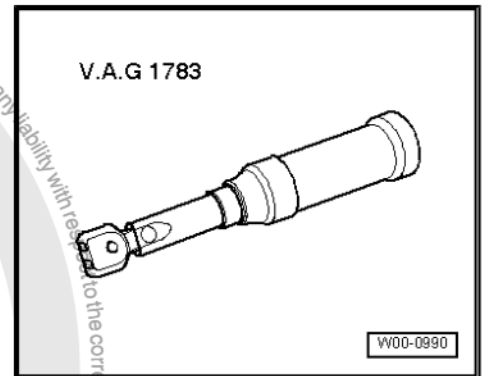
Removal:

- Remove the rear lid lining ➔ General body repairs, interior; Rep. gr. 70 ; Lining / Insulation - Luggage compartment lining .
- Disengage the operating clip -10-.
- Disengage the operating rod -12-.
- Disengage motor for unlocking rear door - V139- operating rod from bushing -11-.
- Remove the fastening screws of the cylinder -14- .
- Disengage the cylinder.

Installation:

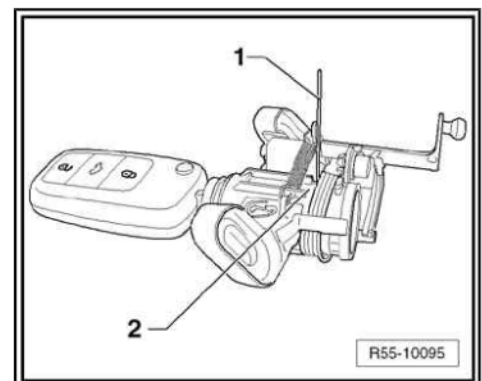
Installation is performed in reverse to the removal sequence, observing the following:

- Place cylinder in order to centralize it in rear door external hole -arrows- and place cylinder -1- slot vertically. The elongated holes on the cylinder housing allow this adjustment.



2.12 Latch cylinder - disassemble

- Remove the latch cylinder ➔ [page 28](#) .
- Insert the key in the cylinder.
- With a \varnothing 2 mm -1- pin, in the hole under the spring -2-, and press the cylinder lock.
- Remove the key along with the cylinder.





3 Rear lid (Spacefox / Suran)

3.1 Rear lid - assembly overview



WARNING

- ◆ When handling chemicals follow the safety instructions ⇒ Chemical Products Manual; Rep. gr. 00
- ◆ Assignment of Chemical Materials ⇒ Electronic Parts Catalogue "ETKA"

1 - Draining membrane

2 - Adjustment buffer

- Adjust ⇒ [page 34](#)

3 - Lid damper lock

4 - Rear lid shock absorber

- Remove and install ⇒ [page 31](#)
- Replace ⇒ [page 32](#)
- Lubricate eyelets with lubricating grease - G 052 745 A3-

5 - Bolt

- 2 units
- Torque 8 Nm

6 - Rear lid buffer

- Remove rear panel lining for access ⇒ General body repairs, interior; Rep. gr. 70 ; Lining / insulation .
- Adjust: through elongated holes.
- Clearance dimensions ⇒ Body Repairs; Rep. gr. 00 ; Technical data - Body clearance dimensions .

7 - Rear lid trim

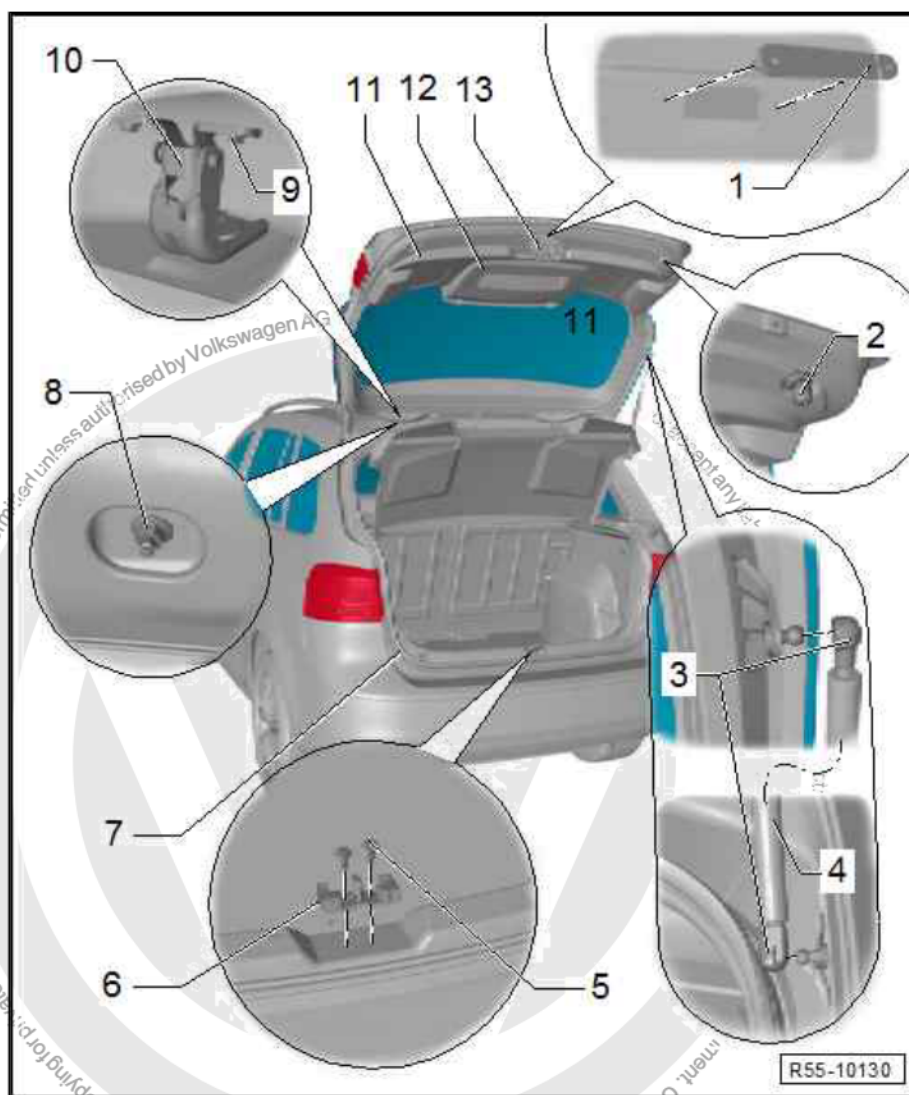
- Remove and install ⇒ [page 32](#)

8 - Fastening nut

- 1 unit
- Torque 24 Nm

9 - Bolt

- 2 units
- Torque 10 Nm





10 - Lid hinge

11 - Rear lid

- ❑ Remove and install ➔ [page 32](#)

12 - Hatch lining

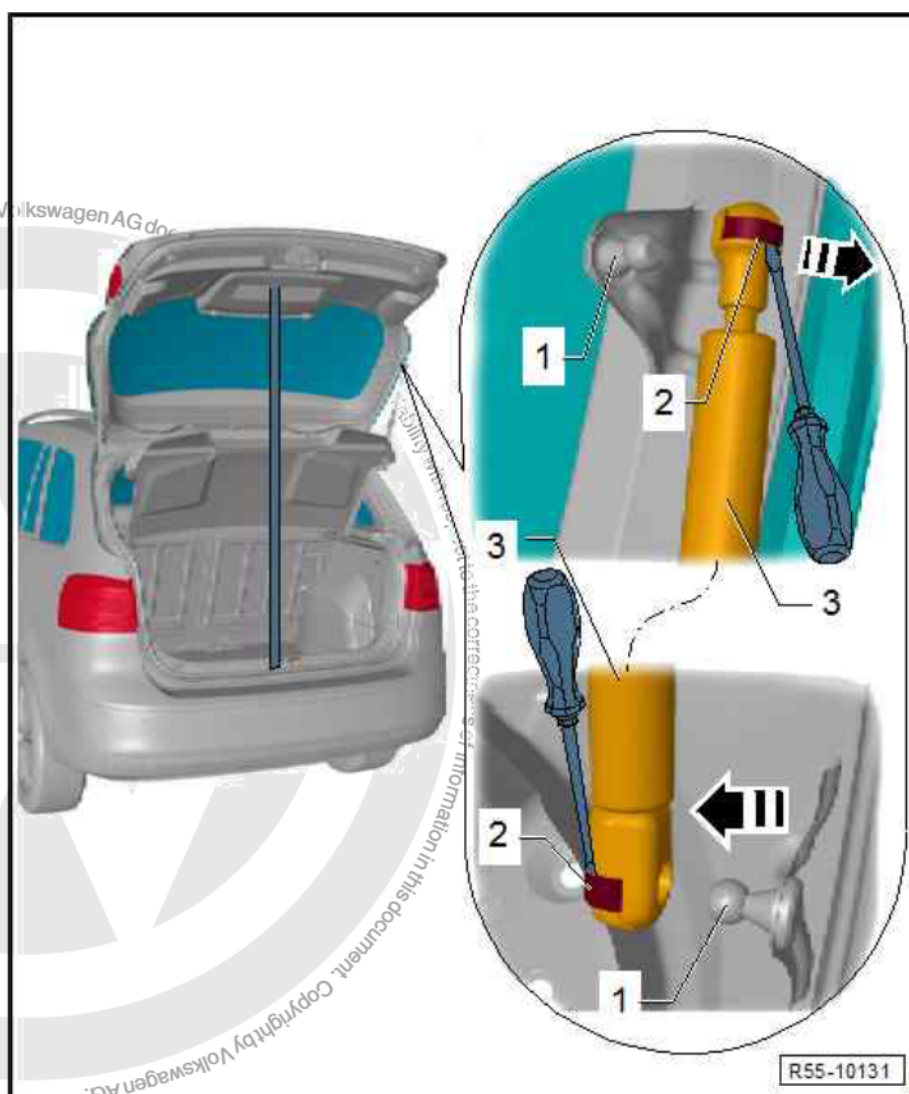
- ❑ Remove and install ➔ General body repairs, interior; Rep. gr. 70 ; Lining / Insulation - Rear lid lining - remove and install .

13 - Rear door latch

- ❑ Remove and install ➔ [page 34](#)

3.2 Rear door shock absorber - remove and install

- Support the rear lid.



- Place a small screwdriver underneath the spring clip -2-.
- Raise the clip -2-enough to allow the clip to move over the ball joint housing in the -direction of arrow-.
- Pull the gas shock absorber -3- from the joint pins -1-.



- After removing the shock absorber -1-, move the clip -2- back immediately.



Note

Be careful when installing the shock absorber. The clip -2- cannot be completely disengaged from the ball joint housing; otherwise, it will be damaged. If the shock absorber fastening is damaged, there is the risk of accident or personal injury.

3.3 Rear door shock absorber - replace

See Rear lid damper - replace ⇒ [page 21](#)

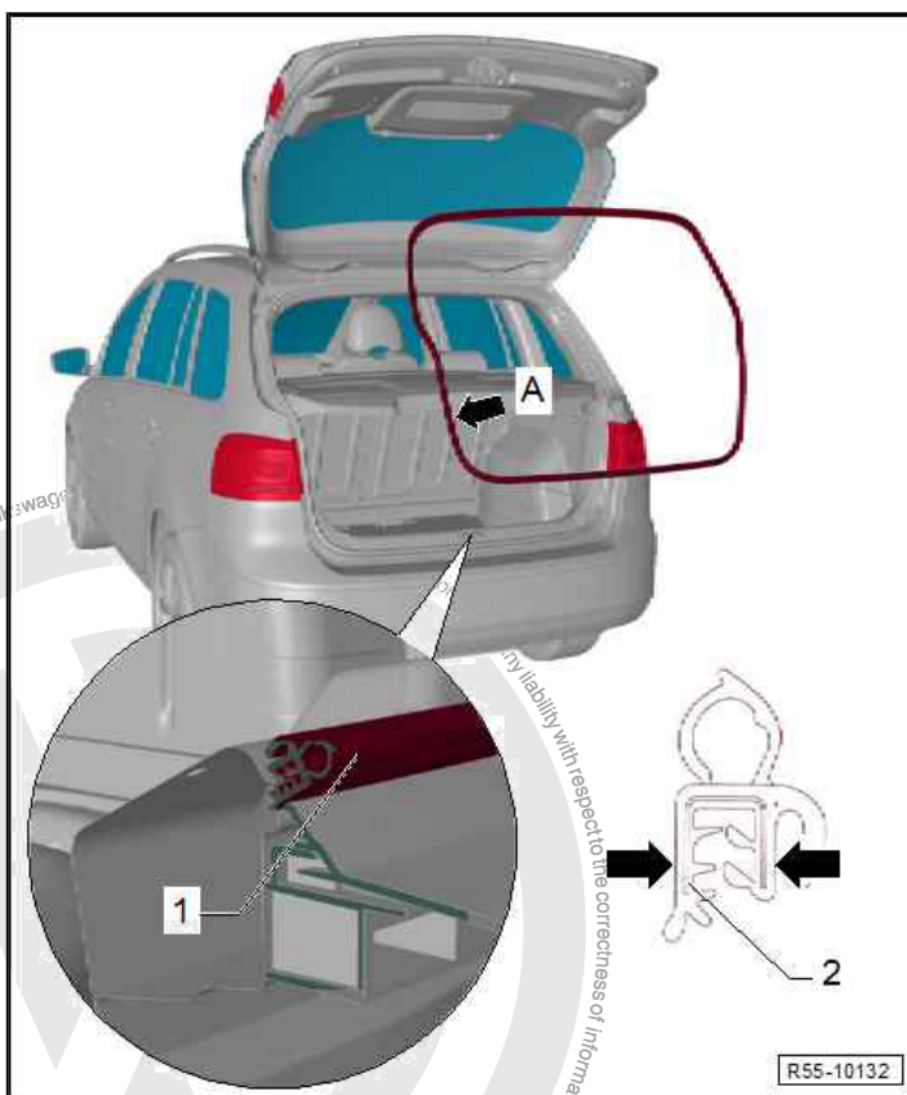
3.4 Rear lid trim - remove and install

1 - Sealing trim

- ❑ Start with the flange next to the left rear light to install the trim -arrow A-.
- ❑ New part installation shall be carried out by slightly tapping with a rubber hammer

2 - Trim metal frame

- ❑ For partially removed trim, it is necessary to press the trim's sides -arrows- before assembly.



3.5 Rear lid - remove and install

Removal:

- Open rear door -1-
- Remove the rear lid lining ⇒ General body repairs, interior, Rep. gr. 70 ; Lining / insulation



- Disengage electric connections and the rear window washer hose.
- Remove electric harnesses from door.
- Release the bolts -3- from the hinge -4-.

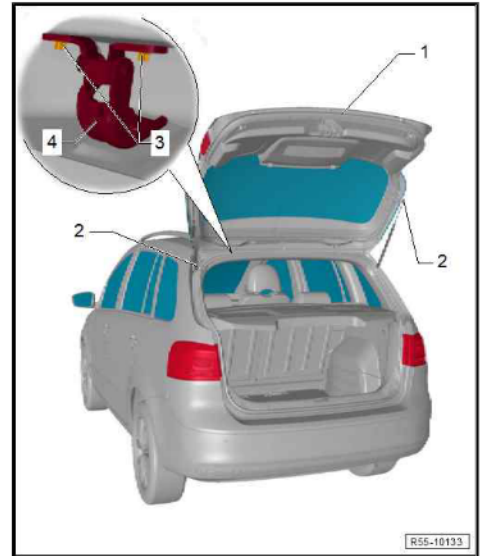
For the items below, you will need the help of an assistant.

- Remove the rear door shock absorber rod -2- from the rear door -1-.
- Remove the bolts -3- and remove the lid.

Installation:

Installation is performed in reverse to the removal sequence, observing the following:

- Torque of the bolts: 10 Nm
- Adjust the cover ⇒ [page 34](#) .
- Before closing the rear door, check rear door locking device motor operation.



3.6 Rear lid hinge - remove and install

Removal:

- Remove the rear lid ⇒ [page 32](#) .
- Remove the C-pillar covering ⇒ General body repairs, interior; Rep. gr. 70 ; Lining / insulation; C-pillar lining - remove and install .
- Remove the D-pillar covering ⇒ General body repairs, interior; Rep. gr. 70 ; Lining / insulation; D-pillar lining - remove and install .
- Lower the headliner.
- Remove the nut -1- that fastens the hinge to the rear roof cross member.

Installation:

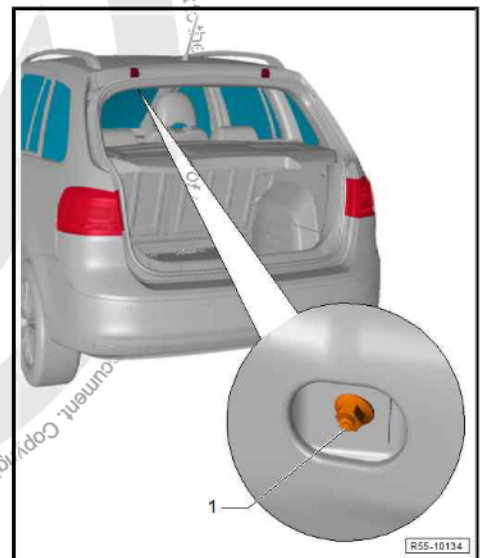
Installation is performed in reverse to the removal sequence, observing the following:



Note

Apply torque to the union nut in the hinge after installing the rear lid.

- Install the lid and tighten the nut temporarily.
- Install the rear lid.
- Tighten the hinge union nut to a torque of 24 Nm
- Install the C-pillar covering ⇒ General body repairs, interior; Rep. gr. 70 ; Lining / insulation; C-pillar lining - remove and install .
- Install the D-pillar covering ⇒ General body repairs, interior; Rep. gr. 70 ; Lining / insulation; D-pillar lining - remove and install .





3.7 Rear lid - adjust

Refer to: Rear lid - adjust ➤ [page 24](#)

3.8 Rear lid lock - remove and install

Refer to "Rear lid lock - remove and install" ➤ [page 25](#)

3.9 Rear lid unlocking motor -V139- (version 1) - remove and install

1 - Rear lid unlocking motor - V139-

☐ Remove:

- Remove the rear lid lining ➤ General body repairs, interior; Rep. gr. 70 ; Lining / insulation .
- Disconnect the connector -8-.
- Disengage rod -2- from bushing -4-.
- Remove the rivets -6- (3 units).
- Remove support -5- with the cover plate motor.

☐ Install:

- Installation is performed in the reverse sequence of the removal.

2 - Operating rod

3 - Latch cylinder

4 - Bushing

- ☐ Replace, as required

5 - Engine support

6 - Rivets

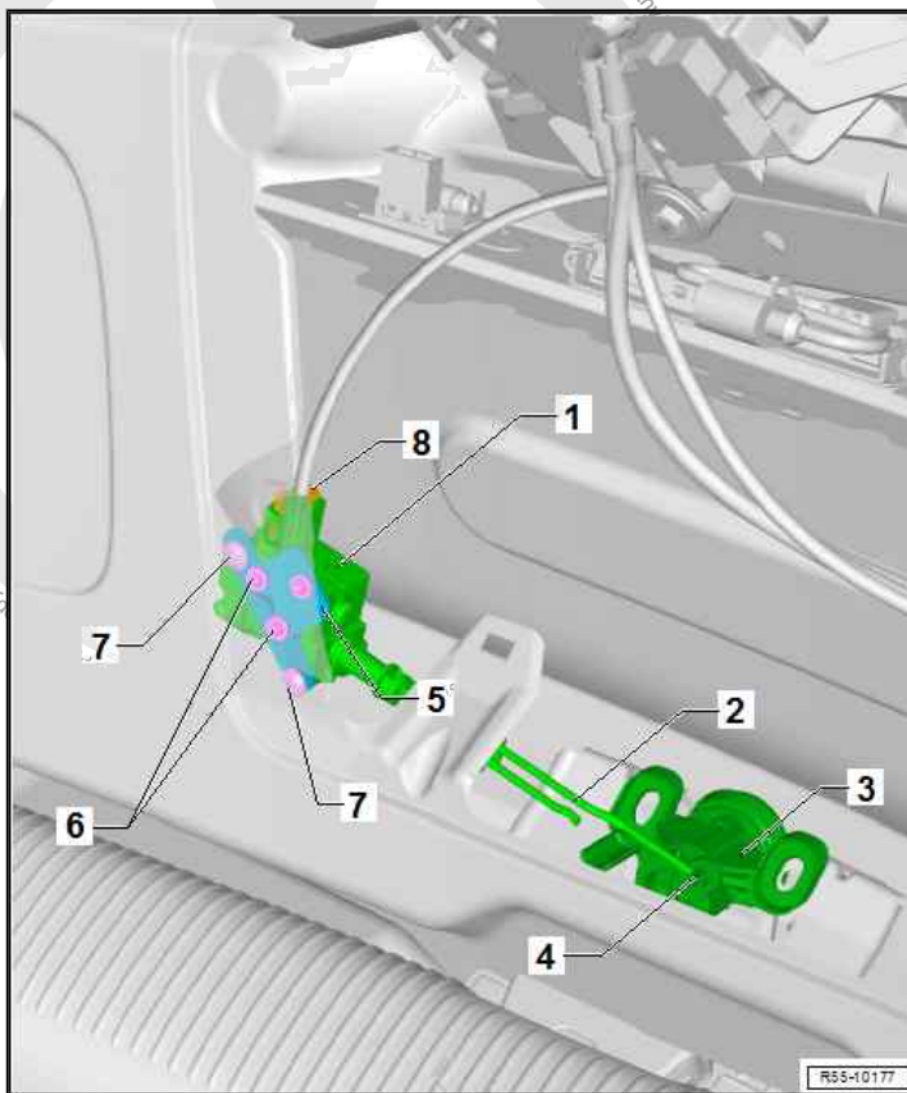
- ☐ 3 units

7 - Bolts

- ☐ 2 units

- ☐ Torque: 2.5 Nm

8 - Connector





3.10 Rear lid unlocking motor -V139- (version 2) - remove and install

1 - Rear lid unlocking motor - V139-

☐ Remove:

- Remove the rear lid lining ⇒ General body repairs, interior; Rep. gr. 70 ; Lining / insulation .
- Disconnect the connector -7-.
- Disengage rod -2- from bushing -4-.
- Remove the bolts -5-.
- Remove support -6- with the cover plate motor.

☐ Install:

- Installation is performed in the reverse sequence of the removal.

2 - Operating rod

3 - Latch cylinder

4 - Bushing

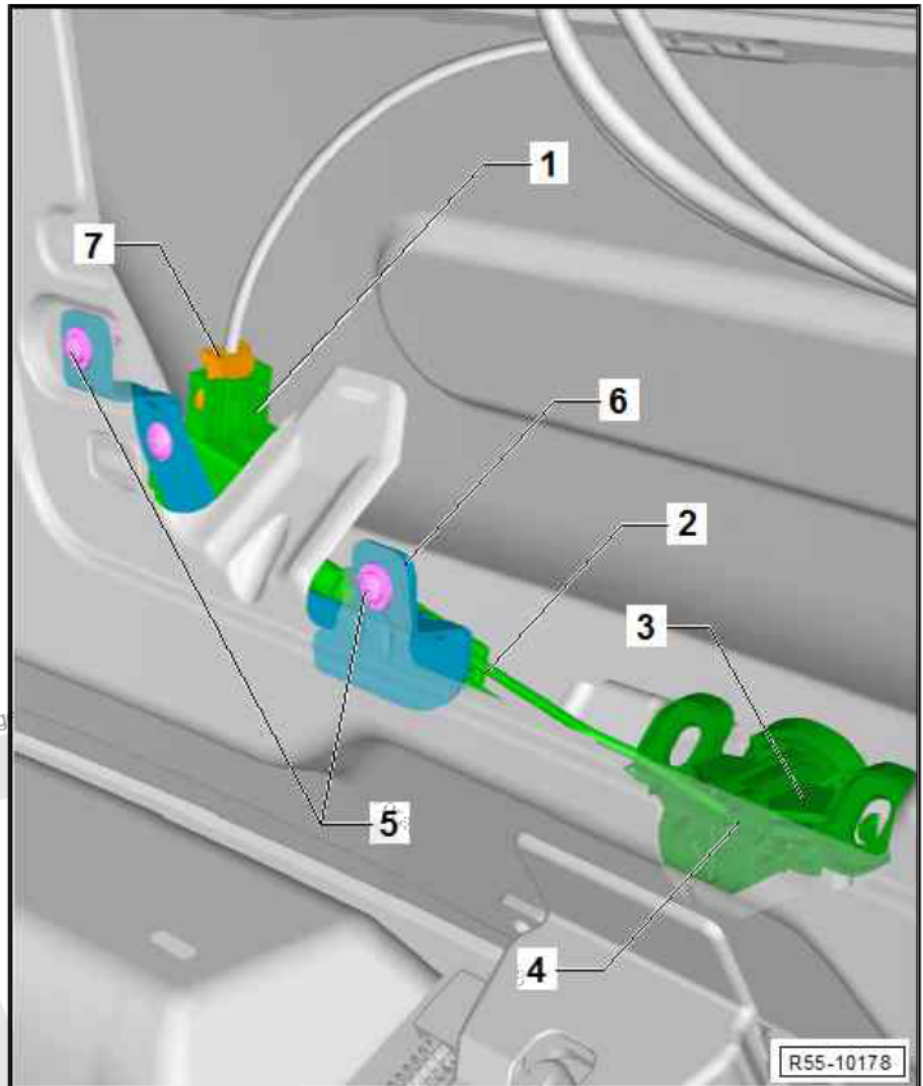
- ☐ Replace, as required

5 - Bolts

- ☐ 2 units
- ☐ Torque: 8.2 Nm

6 - Engine support

7 - Connector



3.11 Lock cylinder - assembly overview

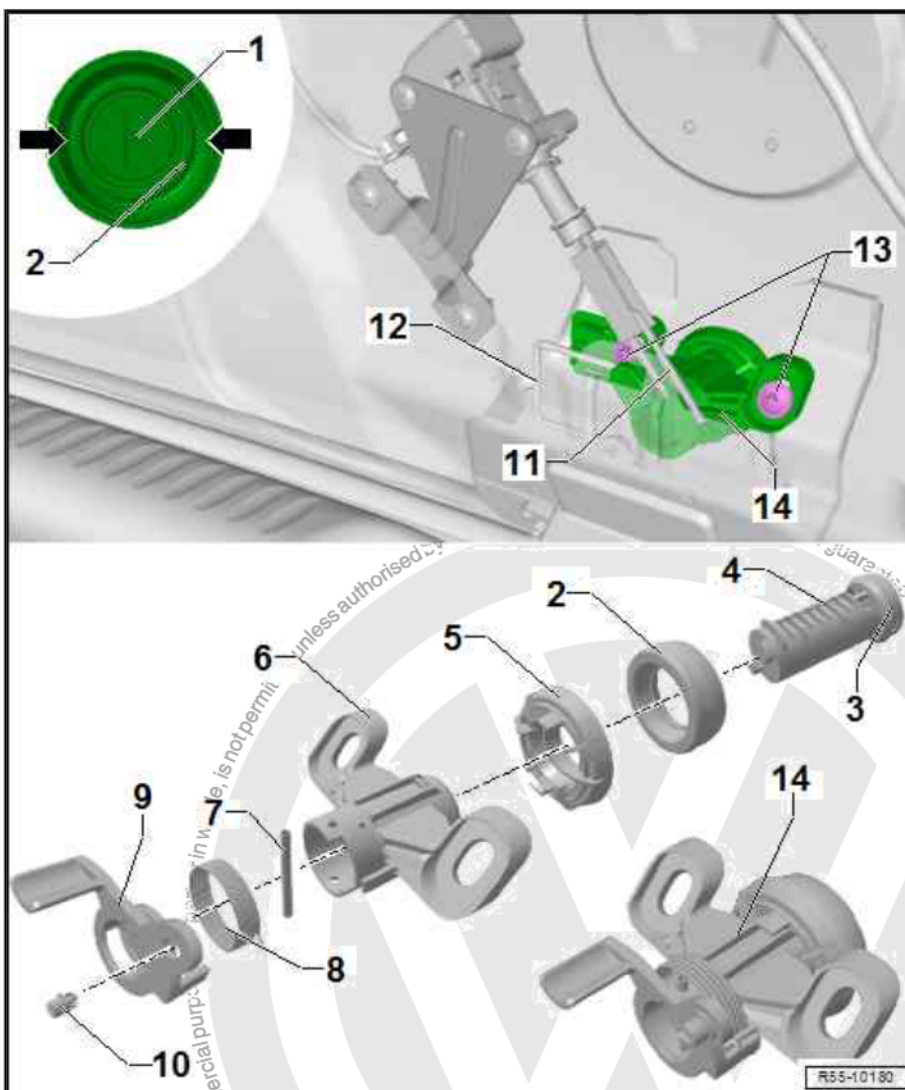


WARNING

- ◆ When handling chemicals follow the safety instructions ⇒ Chemical Products Manual; Rep. gr. 00
- ◆ Assignment of Chemical Materials ⇒ Electronic Parts Catalogue "ETKA"



- 1 - Key passage slot in cylinder
- 2 - Sealing ring
 - ❑ Fastened to the support -5-
- 3 - Cylinder sealing ring
- 4 - Cylinder
 - ❑ Lubricate with special grease - G 000 450 02- .
- 5 - Sealing ring support
- 6 - Cylinder housing
- 7 - Elastic pin
- 8 - Return spring
- 9 - Actuator
 - ❑ Locking system.
 - ❑ fastened by the elastic pin -7-.
- 10 - Clip
- 11 - Operating rod for Rear lid release motor - V139-
- 12 - Latch selector rod
- 13 - Bolt
 - ❑ 2 units
 - ❑ Torque: 8 Nm
- 14 - Assembled cylinder set

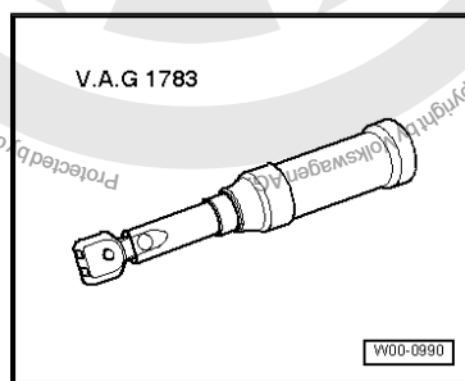


3.12 Latch cylinder - remove and install

Torque wrench 2 to 10 Nm - VAG 1783-

Removal:

- Remove the rear lid lining ⇒ General body repairs, interior; Rep. gr. 70 ; Lining / Insulation - Luggage compartment lining .
- Disengage the operating clip -10-.
- Disengage the operating rod -11-.
- Remove the fastening screws of the cylinder -13- .



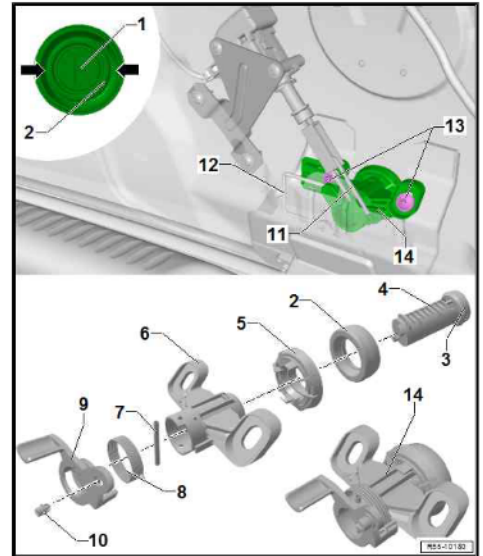


- Disengage the cylinder.

Installation:

Installation is performed in reverse to the removal sequence, observing the following:

- Place cylinder in order to centralize it in rear door external hole -arrows- and place cylinder -1- slot vertically. The elongated holes on the cylinder housing allow this adjustment.



3.13 Latch cylinder - disassemble

Refer to "Latch cylinder (Fox) - disassemble" ⇒ [page 29](#)

3.14 Bonnet latch handle - remove and install

1 - Bolt

- ☐ Torque: 4 Nm

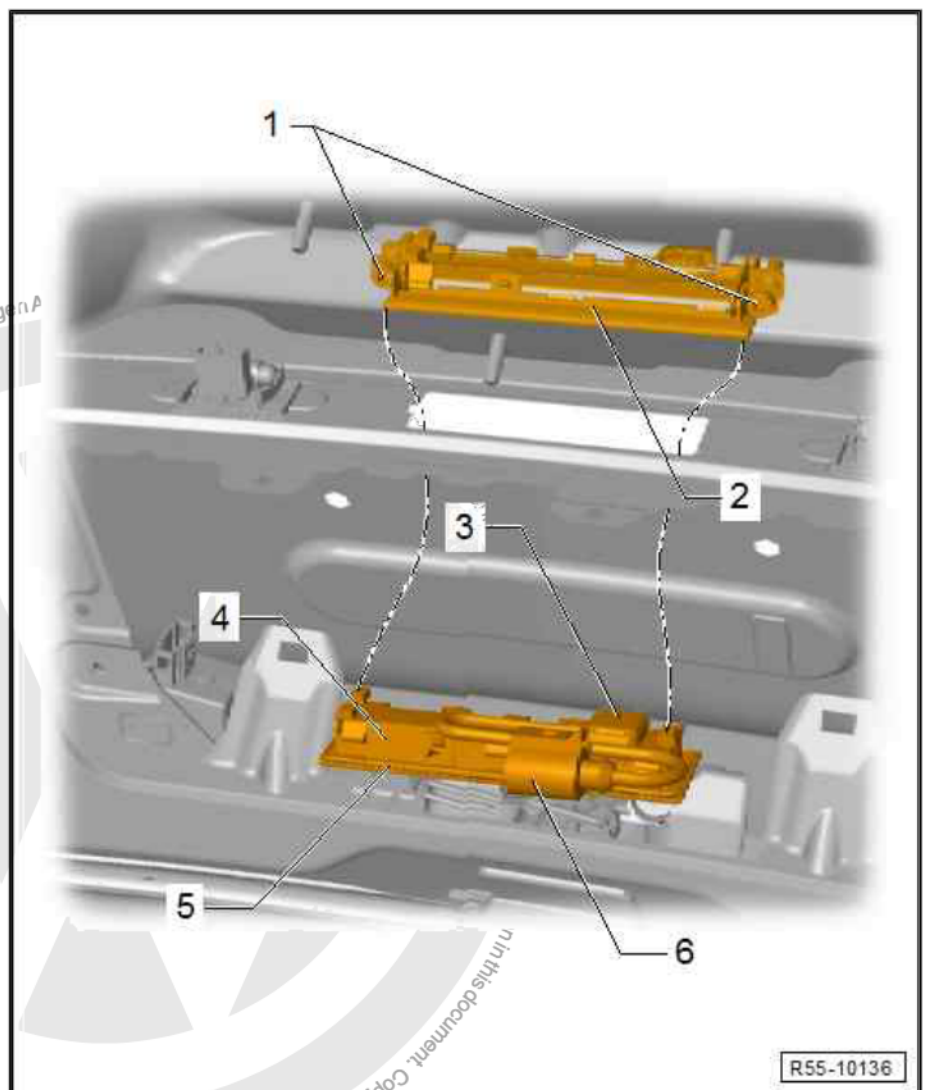
2 - Fastening support

3 - Rear lid contact switch - F111-

4 - Handle with activator

5 - Sealing

- ☐ EPDM / PP





6 - Connector

Removal:

- Remove and install the Rear lid lining ⇒ General body repairs, interior; Rep. gr. 70 ; Lining / insulation - Rear lid linings - remove and install
- Disconnect the connector from -6- harness to rear lid contact switch. - F111- .
- Release bolts -1-, holding the handle from outside.
- Remove handle.

Installation:

- Installation is performed in the reverse sequence of the removal.

3.15 Fastening of the rear license plate - install

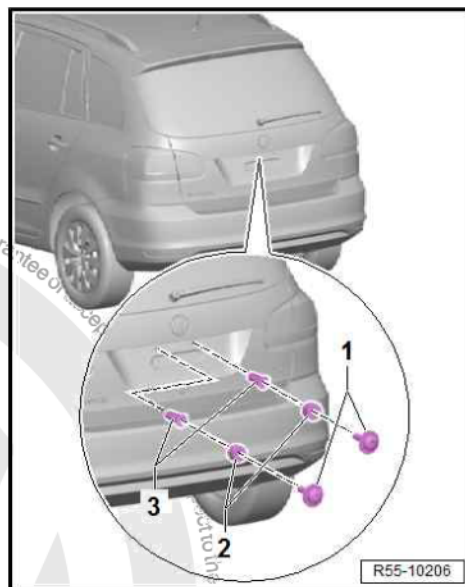
- Install the screws -1- along with the rubber spacers -2- in the bushings -3-.

1= screw - N 014 141 12-

2= Spacer - ZBA 813 865-

3= Bushing - N 906 481 02-

Correspondence: ⇒ Electronic Parts Catalogue "ETKA" .





4 Fuel reservoir nozzle compartment and lid set

4.1 Fuel tank nozzle compartment and lid set - remove and install

1 - Side panel

2 - Bushing

3 - Fuel reservoir nozzle compartment and lid set

- ☐ Constituted by fuel reservoir lid -4- and reservoir nozzle compartment -6-.

- ☐ Remove:

- Fuel tank cap.
- Loosen the screw -5-.
- Remove rubber part from fuel reservoir nozzle and turn the lid set outwards the side panel.

- ☐ Install:

- First assemble the fuel nozzle compartment and lid set (fitted rubber part) with the hinge side.
- Tighten the screw -5-.

4 - Fuel tank cap

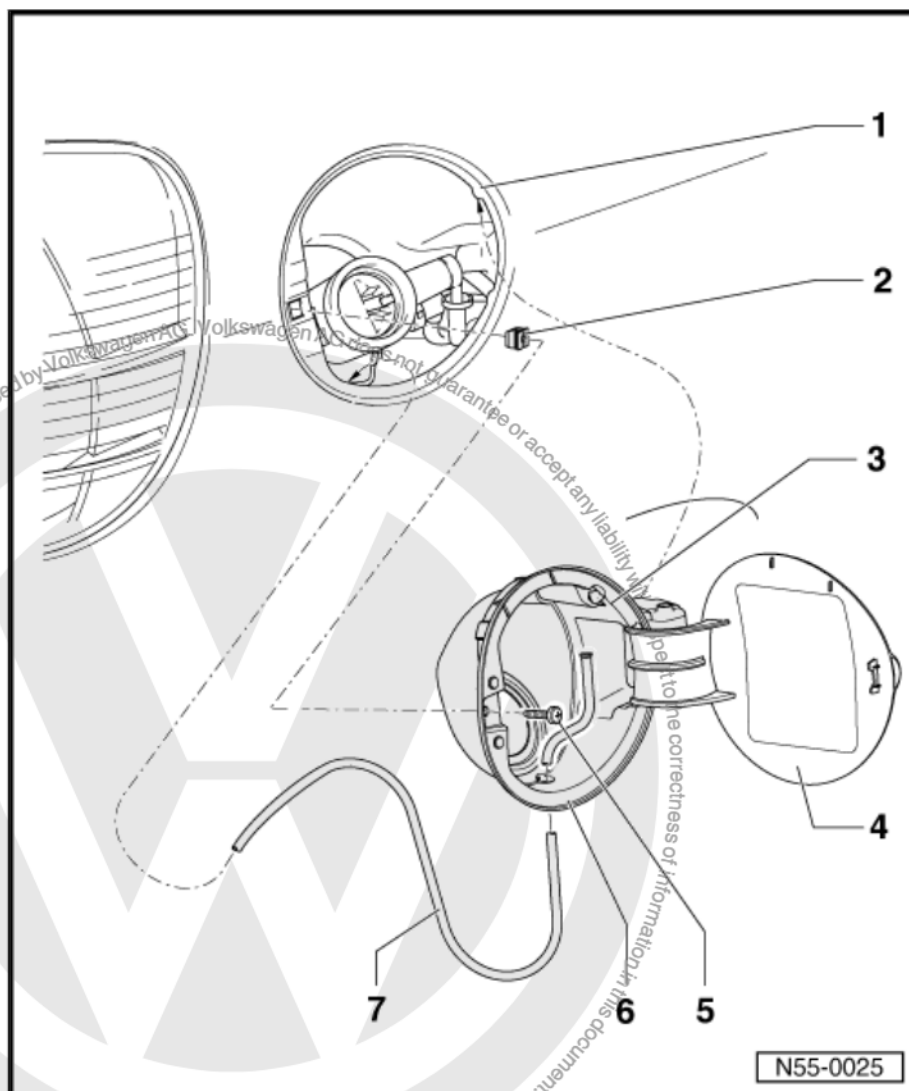
- ☐ Can only be removed as refuelling nozzle lid unit -3-.
- ☐ To remove fuel reservoir lid, press fastening pin of the refuelling nozzle door unit.

5 - Bolt

6 - Fuel nozzle lid compartment

- ☐ Can only be removed with the fuel reservoir nozzle compartment and lid set -3-.
- ☐ To remove fuel reservoir lid, press fastening pin of fuel nozzle lid.

7 - Draining hose





57 – Front doors, door components, central locking

1 Front door

1.1 Front door - assembly overview



WARNING

- ◆ When handling chemicals follow the safety instructions → *Chemical Products Manual; Rep. gr. 00*
- ◆ Assignment of Chemical Materials → *Electronic Parts Catalogue "ETKA"*

1 - Door arrester

- ☐ Adjust ⇒ [page 45](#)

2 - Bolt

- ☐ Torque: 25 Nm

3 - Door lock rod

- ☐ In 2013 ► models, versions with electric locking do not have this rod.
- ☐ On -locked door- position, button on locking rod shall be "0 to 2 mm" above the button frame. Use puller and fitter - VW 035- .

4 - Eyelet

- ☐ In 2013 ► models, versions with electric locking do not have this eye.

5 - Door lock

- ☐ Remove and install ⇒ [page 53](#)
- ☐ Lubricate with low-temperature grease -G 052 745 A3- .

6 - Bolt

- ☐ Torque: 20 Nm

7 - Bushing

- ☐ Replace, as required

8 - Activation lever

9 - Lock Bowden cable

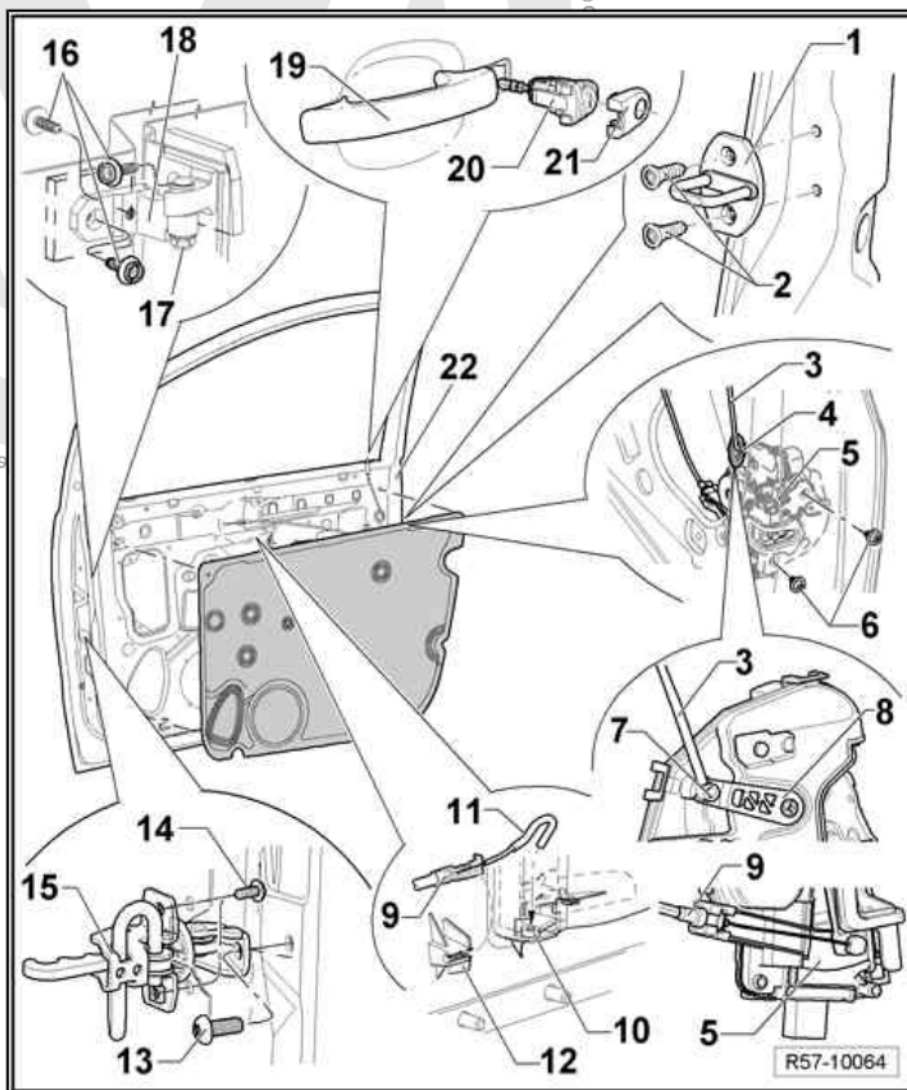
- ☐ Replace ⇒ [page 55](#)

10 - Interior handle

11 - Lock Bowden cable hook

12 - Cable support

- ☐ On the door lining



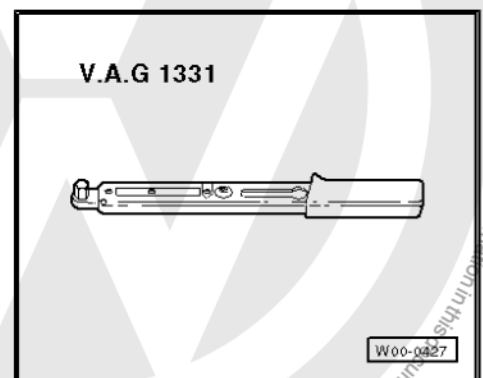


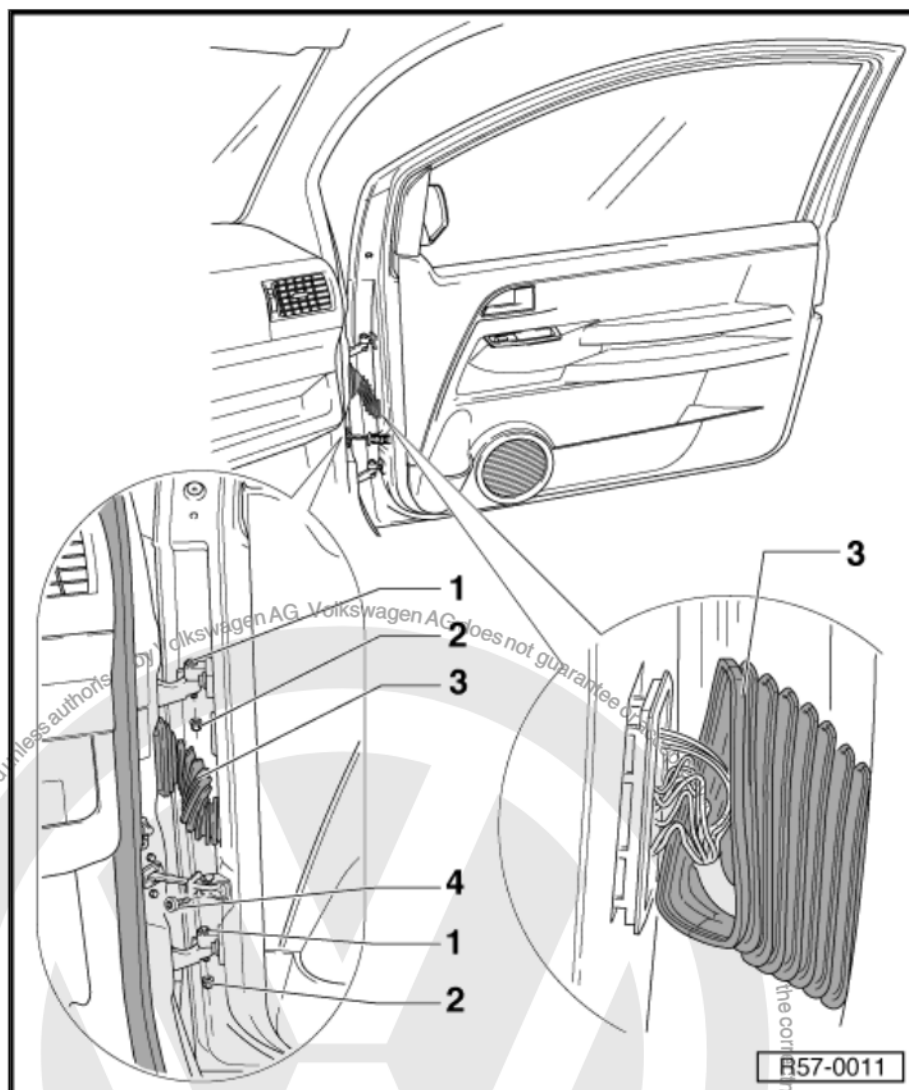
- 13 - Bolt
 - ☐ Torque: 25 Nm
- 14 - Bolt
 - ☐ Torque: 10 Nm
- 15 - Door limiter
 - ☐ Remove and install ⇒ [page 45](#)
- 16 - Multi-tooth screw
 - ☐ M 8
 - ☐ Torque: 20 Nm + 1/4 turn (90°)
 - ☐ Screws must always be replaced when removed
- 17 - Nut
 - ☐ Torque: 14 Nm
- 18 - Door hinge
 - ☐ In two sections
- 19 - External door handle
 - ☐ Remove and install ⇒ [page 51](#)
- 20 - Lock cylinder housing, or housing without lock cylinder
 - ☐ Remove and install ⇒ [page 48](#)
- 21 - Cover cap
- 22 - Door
 - ☐ Remove and install ⇒ [page 41](#)
 - ☐ Adjust ⇒ [page 42](#)
 - ☐ Disassemble and assemble ⇒ [page 44](#)
 - ☐ Replace ⇒ [page 44](#)

1.2 Front door - remove and install

Special tools and workshop equipment required

- ◆ Torque wrench - 5 to 50 Nm (1/2" drive) - VAG 1331-





Removal:

- Pull protection bellows -3- from A-pillar and disconnect electric connections of coupling station located on A-pillar.
- Remove nuts -2- from hinge pins -1-.
- Remove the screw -4- from the door limiter.
- Disengage door upward and out of hinge angle bars.

Installation:

Install is performed in the reverse sequence, observing the following:

- Tighten the nuts -2- of the hinge pins to a torque of: 14 Nm.
- Tighten the screw -4- of the door limiter to a torque of: 25 Nm.

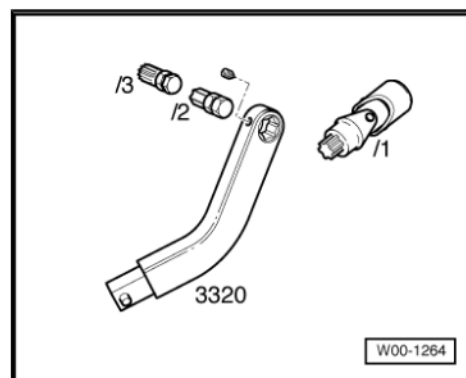
1.3 Front door - adjust

Special tools and workshop equipment required

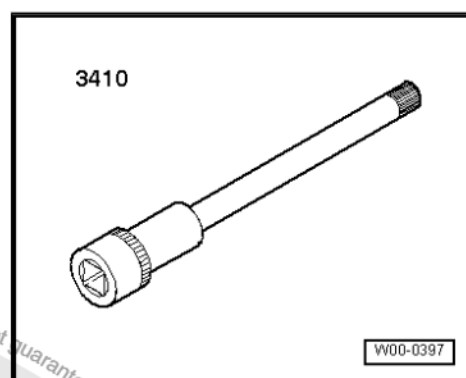
- ♦ Wrench - 3320-



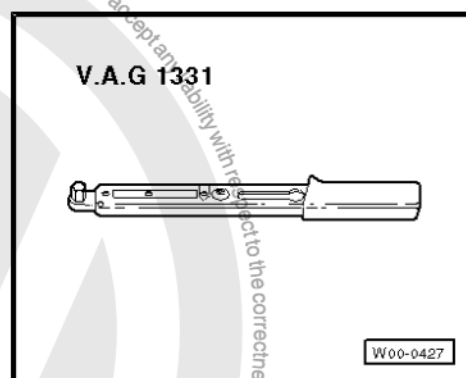
- ◆ Multi-tooth bits - 3320/3-



- ◆ Multi-teeth socket - 3410-



- ◆ Torque wrench - 5 to 50Nm (1/2" drive) - VAG 1331-



Note

- ◆ *Vehicle must be supported by its wheels in order to correctly adjust the front door.*
- ◆ *The front door is correctly adjust when clearances are as specified ⇒ Body Repairs; Rep. gr. 00; Technical data - Body clearance dimensions when door is locked.*
- ◆ *Take anticorrosion protection measures on hinges and screws after reinstalling or adjusting.*

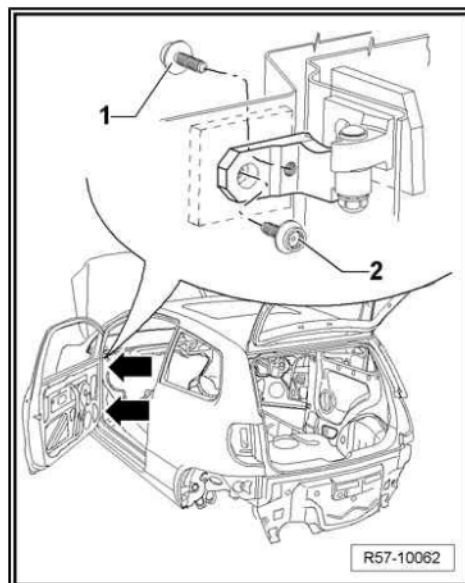


Screws -1- and -2- must be loosen on A-pillar in order to correctly adjust clearances.

- For screw -1- on lower door hinge, lower longitudinal member trim must be removed: ⇒ General body repairs, interior; Rep. gr. 68 ; Internal equipment . Loosen screw with multi-tooth socket - 3410- .
- For screw -1- on upper door hinge, the dashboard must be removed: ⇒ General body repairs, interior; Rep. gr. 70 ; Linings / insulations Loosen bolt with multi-tooth socket - 3410- .

For screw -2- , loosen it with wrench - 3320- and multi-tooth bits - 3320/3- .

Adjust the door arrester ⇒ [page 45](#) .



1.4 Front door - disassemble and assemble

Disassemble:

- Remove the door lining ⇒ General body repairs, interior; Rep. gr. 70 ; Lining / insulation .
- Remove the door sealing membrane ⇒ [page 55](#) .
- Remove the door window drive mechanism:
 - Manual drive ⇒ [page 152](#) .
 - Electrical drive ⇒ [page 151](#)
- Remove the door window glass ⇒ [page 147](#) .
- Remove the external rear-view mirror ⇒ [page 234](#) .
- Remove the internal and external door window trims ⇒ [page 153](#) .
- Remove the door window channel ⇒ [page 153](#) .
- Remove the glass guide rail.
- Remove the external handle ⇒ [page 51](#) .
- Remove the lock ⇒ [page 53](#) .
- Remove the door limiter ⇒ [page 45](#) .
- Disconnect the protection bellows and remove the harness from inside the door.

Assemble:

- Assembly is performed in the reverse sequence to disassembly.

1.5 Front door - replace

Removal:

- Disassemble the door ⇒ [page 44](#) .
- Remove the door ⇒ [page 41](#) .



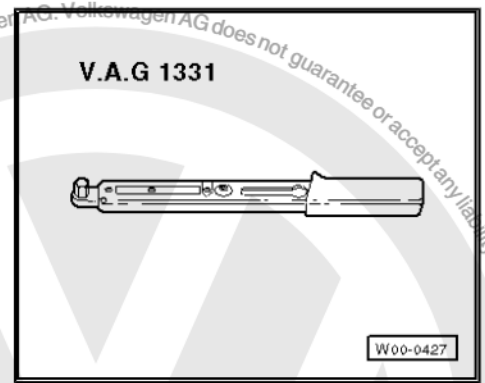
Installation:

- Apply sealant/caulking to the door ⇒ Painting Manual - Body Sealant - Fox .
- Install the door noise insulation ⇒ General body repairs, interior; Rep. gr. 70 ; Lining / insulation .
- Paint the door ⇒ Painting Manual - Repairing paintwork on steel plates and galvanized steel plates.
- Install the door ⇒ [page 41](#) .
- Apply anti-corrosive fluid ⇒ Paint Manual - Application of anti-corrosive fluid - Anti-corrosive fluid .
- Assemble the door ⇒ [page 44](#) .

1.6 Door arrester - adjust

Special tools and workshop equipment required

- ◆ Torque wrench - 5 to 50Nm (1/2" drive) - VAG 1331-



1.6.1 Adjust

- Loosen buffer fastening screws.
- Position buffer and tighten screws temporarily.
- Close the door and check the perfect alignment with the body, check the clearance dimensions specified ⇒ Body Repairs; Rep. gr. 00 ; Technical data - Body clearance dimensions .
- Definitely tighten buffer to:
 - Torque: 25 Nm (multi-teeth)

1.7 Door limiter - remove and install

Special tools and workshop equipment required

- ◆ Torque wrench - 5 to 50 Nm (1/2" drive) - VAG 1331-



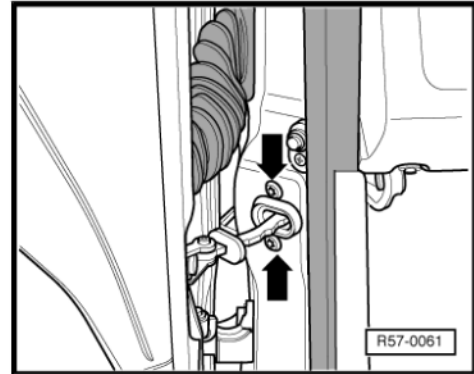


Removal:

- Remove front door threshold trim ⇒ General body repairs, interior; Rep. gr. 68 ; Linings / insulations .
- Remove the door limiter fastening screw (T-40).
- Remove fastening screws -arrows- from limiter on pillar A (T-30).
- Remove limiter.

Installation:

- Installation is performed in the reverse sequence to the removal.



1.8 Front door external handle and lock - Assembly overview



WARNING

- ◆ When handling chemicals follow the safety instructions ⇒ Chemical Products Manual; Rep. gr. 00
- ◆ Assignment of Chemical Materials ⇒ Electronic Parts Catalogue "ETKA"



1 - External handle support

- ☐ Remove the lock cylinder housing
⇒ [page 48](#) .
- ☐ Remove the door handle
⇒ [page 51](#) .
- ☐ Remove the door lining
⇒ General body repairs, interior; Rep. gr. 70 ; Lining / insulation .
- ☐ Remove the sealing membrane in the door handle area.
- ☐ Loosen the screw, push the external handle support a little backwards and remove it from the door.

2 - Bolt

3 - Torx screw

- ☐ Release with the pin-cers - T10072- .
- ☐ When releasing the screw, the fastening of the lock barrel housing is unlocked and can be pulled out of the external handle support.
- ☐ The screw cannot be tightened without the lock barrel housing being placed. The locking ring may fall inside the door.

4 - Door handle

- ☐ Remove and install
⇒ [page 51](#)

5 - Key with remote control

- ☐ Battery replacement ⇒ [page 67](#)
- ☐ Adapting keys with remote or additional control ⇒ [page 69](#)

6 - Cap

7 - Cylinder housing with or without lock cylinder

- ☐ Remove and install ⇒ [page 48](#)
- ☐ Fitted to the door lock and fastened with a screw.

8 - Sealing

9 - Door lock

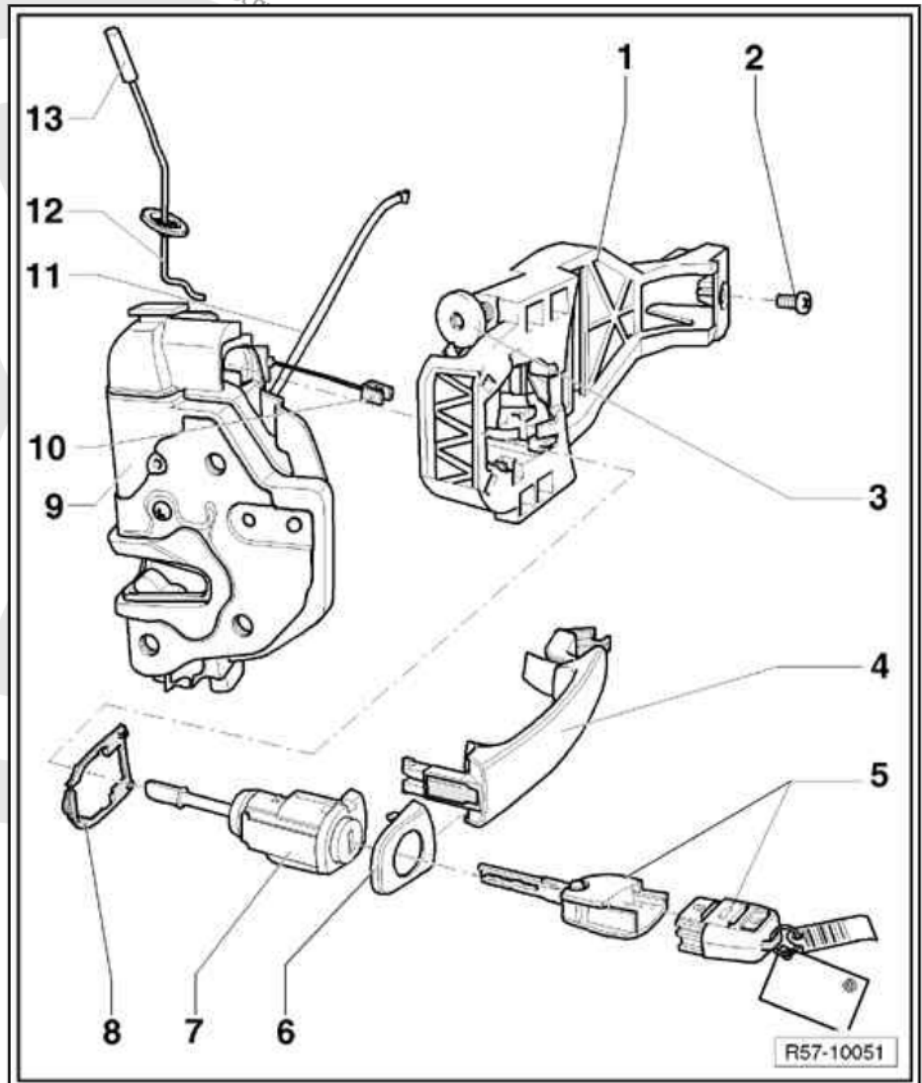
- ☐ Remove and install ⇒ [page 53](#)
- ☐ Central locking motor for driver/passenger door - V56/V57- is integrated to lock set.
- ☐ Lubricate with low-temperature grease -G 052 745 A3-

10 - Operating cable

- ☐ Lock unlocking.

11 - Lock Bowden cable

- ☐ Remove and install ⇒ [page 55](#)





12 - Door lock rod

- ☐ In 2013 ► models, versions with electric locking do not have this rod.

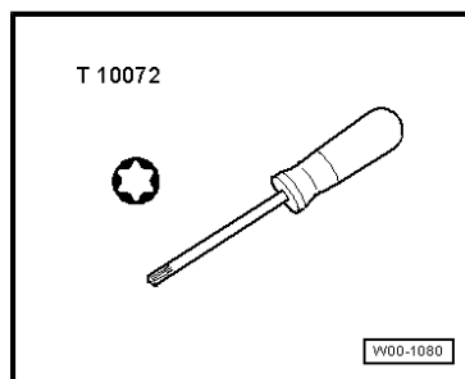
13 - Door lock button

- ☐ In 2013 ► models, versions with electric locking do not have this button.
- ☐ Fastened to the locking rod.
- ☐ Remove and install ⇒ [page 54](#) .

1.9 Lock cylinder housing - remove and install

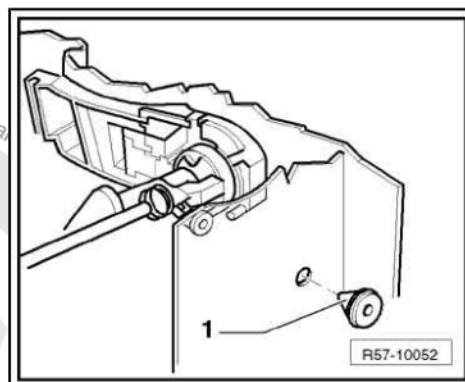
Special tools and workshop equipment required

- ♦ torque wrench - T10072-



Removal:

- Disengage plug -1-.





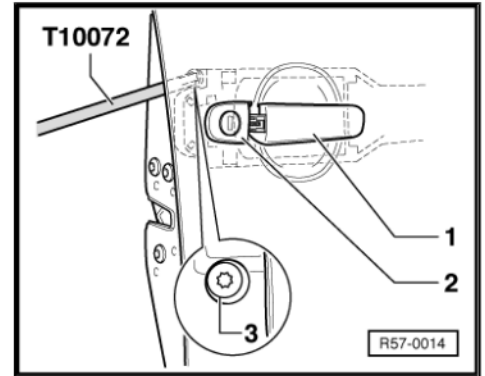
- Pull and hold the door handle -1-. Release the screw -3- with the pincers - T10072- and simultaneously press towards the external handle support. This releases the locking in the lock cylinder housing.



Note

If the screw is excessively released, the locking ring may detach from the external handle support and fall into the door as a result.

- Pull the lock cylinder housing -2- out of the external handle support, at a straight angle in relation to the door handle.



Installation:

Install is performed in the reverse sequence, observing the following:

- Place the lock cylinder housing on the external handle support at a straight angle.
- Then, fasten the screw to the external handle support with the pincers - T10072- .

The door handle is again fitted to the lock cylinder housing when there is an audible click.



Note

During the assembly, you must press the door handle and the lock cylinder housing against the door plate.

1.10 Cylinder housing - disassemble and assemble



WARNING

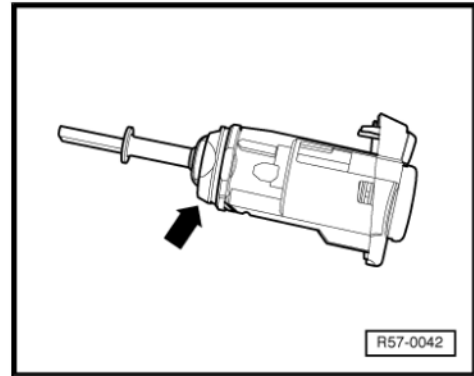
- ◆ When handling chemicals follow the safety instructions ⇒ Chemical Products Manual; Rep. gr. 00
- ◆ Assignment of Chemical Materials ⇒ Electronic Parts Catalogue "ETKA"

Disassemble:

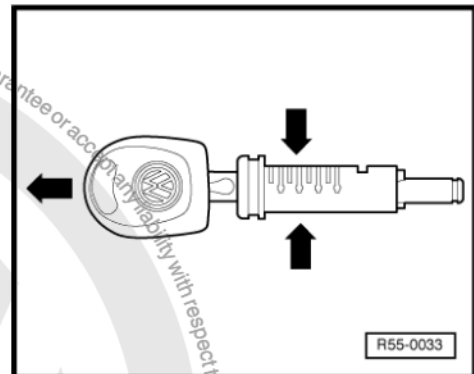
- Remove the lock cylinder housing ⇒ [page 48](#) .
- Insert the key in the cylinder.
- Press key towards cylinder.



- Remove the lock and disengage the operating lever -arrow-.
- Remove the rings, the spring and the cylinder guide.
- Remove cylinder along with key from housing.
- Clean the cylinder, removing all the dirt and grease remains.



- Manually press the gorges into the cylinder, and then carefully remove the key.
- Slowly loosen the cylinder, releasing the pressure from the gorge springs.

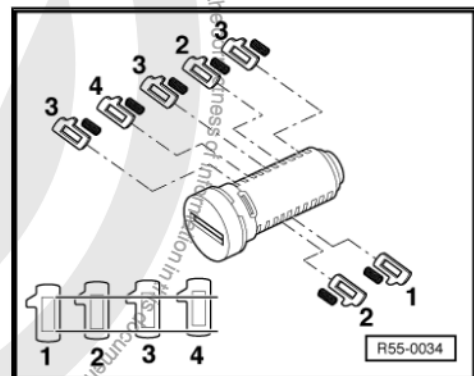


- Remove the gorges and the springs, marking their position in relation to the cylinder.



Note

The gorges are identified by numbers from 1 to 4 (it is also possible to identify them through colors), mark the sequence, in the example - 2 3 1 4 3 2 3, or 2 1, on the lower section, and 3 4 3 2 3 on the upper section.



Assemble:

- Place the springs and gorges in the correct position (sequence).



Note

During this operation, lubricate the gorges and the cylinder with low-temperature grease -G 052 745 A3-.

- When assembling, it is possible to combine gorges depending on the vehicle key, in case of cylinder replacement. To do so, follow the steps below:
- Starting from the last cylinder gorge groove position, insert the spring and gorge number 1. Introduce the key and observe the position of the groove with regards to the cylinder.



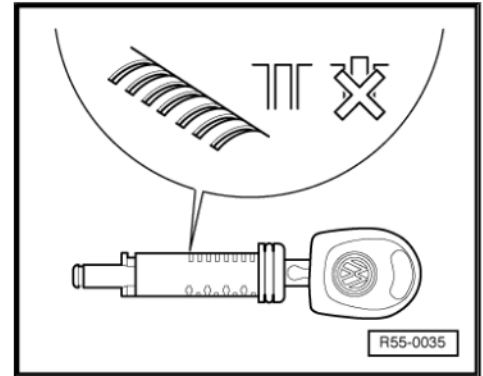
- If the upper gorge section is aligned with the cylinder housing -arrow-, then gorge number 1 is the correct one for this position. Otherwise, place gorge number 2 and so forth until finding the one that is aligned with cylinder when the key is inserted.



Note

Repeat the operation for all other gorge positions in the cylinder. Mark the position (sequence) of the gorges in relation to the cylinder.

- Install the cylinder guide on the housing.
- Insert the cylinder into the guide.
- Position the spring and the rings.
- Install the operating lever.
- Install the lock.
- Install the lock cylinder on the handle ➔ [page 49](#) .
- Install the external handle ➔ [page 51](#) .



1.11 Cylinders and keys (Specific information for Brazil) - request

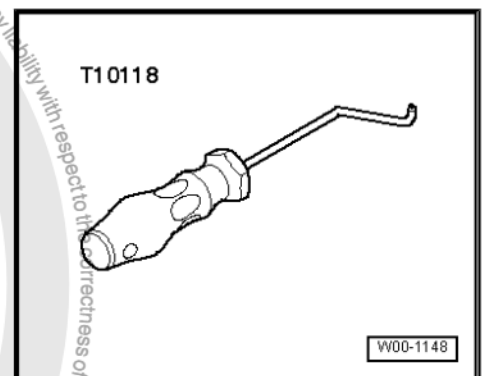
The key may be requested to the parts department with the original key mechanical code. For this purpose, follow the instructions in the Parts Circular Letter, number 156, of June 2004.

Full cylinders may be requested via fax number (5511) 4347-3652, by sending every information about the vehicle (chassis number, original key mechanical code, etc.).

1.12 External door handle - remove and install

Special tools and workshop equipment required

- ◆ Hook - T10118-



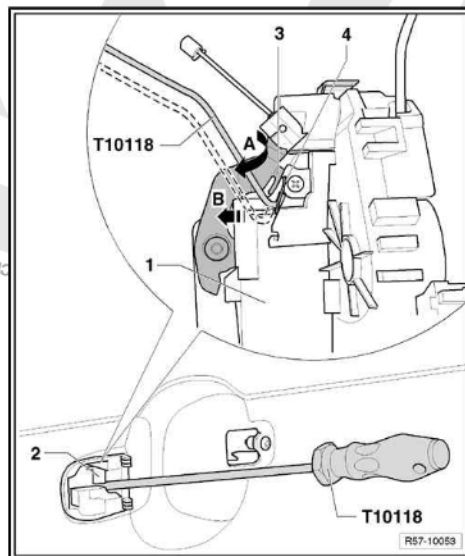
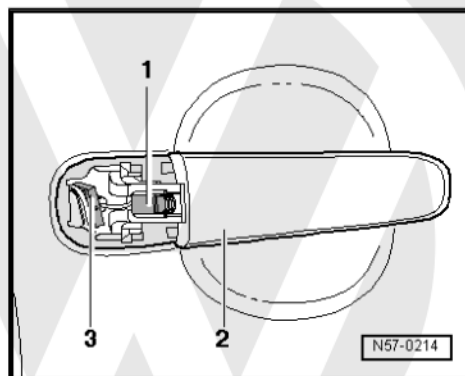


Removal:

- Remove the lock cylinder housing ⇒ [page 48](#) .
- Disengage the clip -1- from the door handle -2-.
- Disengage the door handle -2- from the door panel.

Installation:

- Through the opening on the door panel -1- insert the hook - T 10118- in the door.
- For a better view, illuminate the internal section of the door with a lamp.
- Turn the hook - T 10118- on the spring -4- -arrow A-

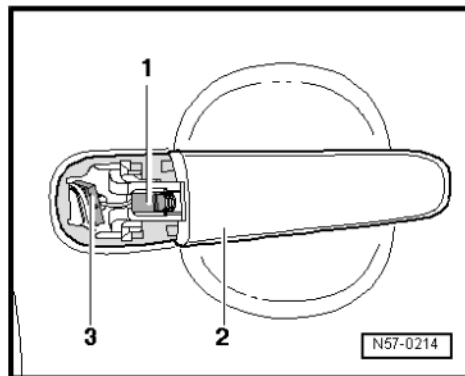


- Pull the hook - T 10118- towards -arrow B-, fasten the spring on lever -3- in the door lock -1-.
- Fit the door handle -2- to the door panel.
- Pull the clip -1- inside the plate cut and fit to the door handle.



Note

When assembling the clip, the latch operating lever -3- cannot be pulled and the door handle -2- must be pressed against the door panel.



- Install the lock cylinder housing ⇒ [page 48](#) .

1.13 External door handle - replace

Removal:

- Remove the external handle ⇒ [page 51](#) .

Installation:

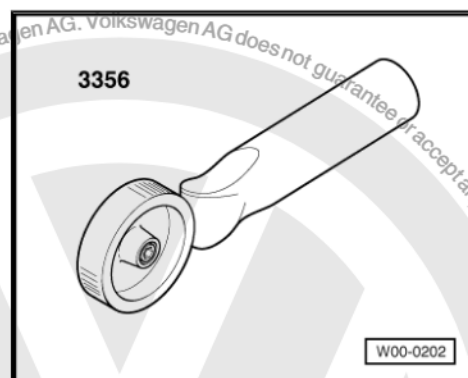
- Paint the handle ⇒ Paint manual - Repairing paintwork in plastic parts .
- Installation is performed in the reverse sequence to the removal.



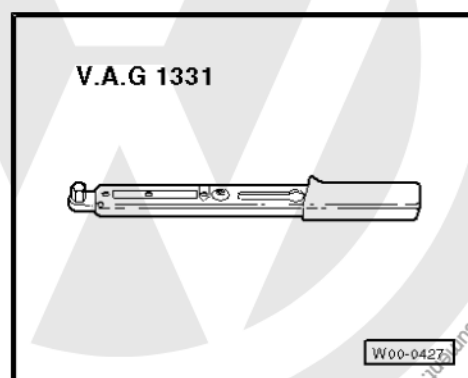
1.14 Door lock - remove and install

Special tools and workshop equipment required

- ◆ Pressure roll - 3356-

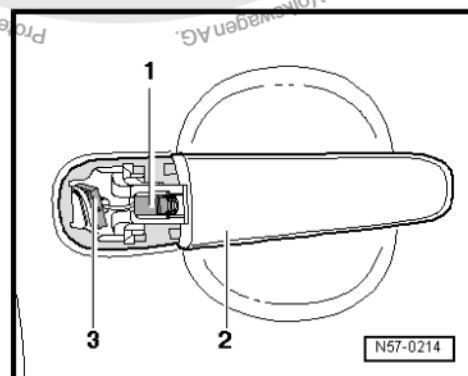


- ◆ Torque wrench - 5 to 50 Nm (1/2" drive) - VAG 1331-



Removal:

- Remove the lock cylinder housing ⇒ [page 48](#) .
- Disengage the clip -1- from the door handle -2-.



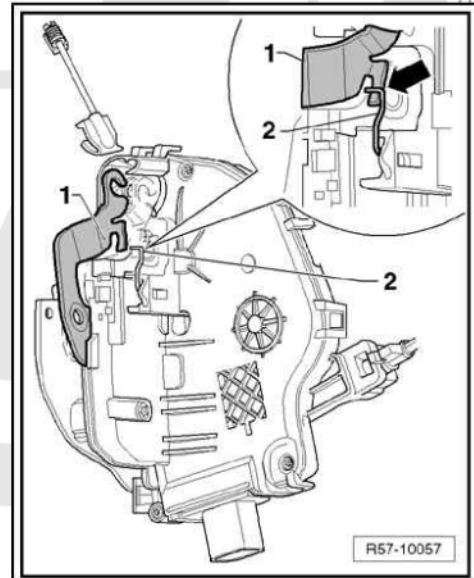
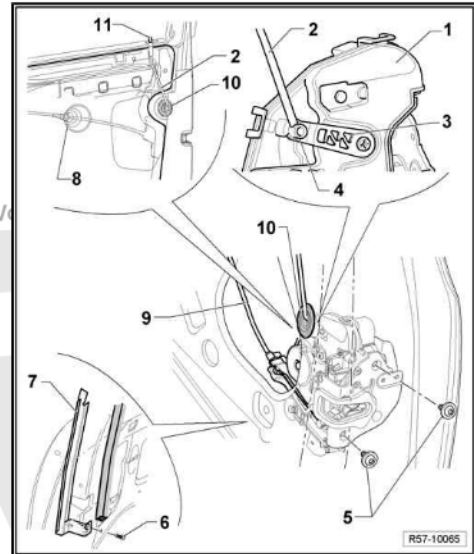


- With the door window closed, remove the front door lining ⇒ General body repairs, interior; Rep. gr. 70 ; Lining / insulation .
- Disengage eyelet -10- from internal door panel and disengage rod -2- from bushing -4- in lever -3-
- Detach adhesive tapes -8- that fasten sealing membrane on the lock operating cable -9-.
- Detach the door sealing membrane to access the lock.
- Remove the screw -6- (Torque: 8 Nm) and move guide rail -7- to remove the lock.
- Disconnect the connector from the central locking motor for driver/passenger door - V56/V57- in the lock.
- Remove the securing bolts -5- (Torque: 20 Nm) from the door lock -1- and remove the lock through the installation opening.

Installation:

Installation is performed in reverse to the removal sequence, observing the following:

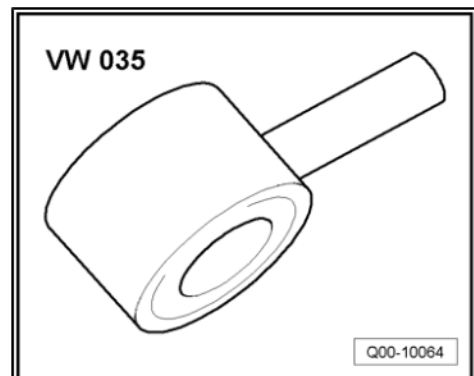
- Place spring -2- under the lock operating lever -1-, with thin nose pliers.
- Installation is performed in the reverse sequence to the removal.



1.15 Lock button (locking rod) - remove and install

Special tools and workshop equipment required

- ◆ Puller and fitter - VW 035-





Removal:

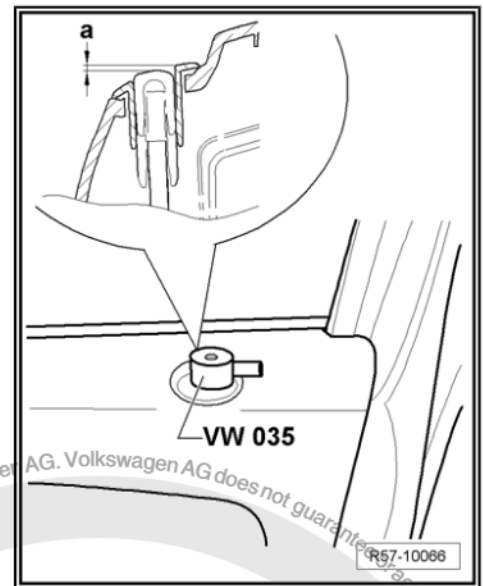
- With the lock button totally raised, fit Puller and Fitter - VW 035- and loosen the pin.
- Remove the tool with the button.

Installation:

Installation is performed in reverse to the removal sequence, observing the following:

- Insert button in the Puller and fitter - VW 035- and screw the button in order that, when in locked position, it is at a distance -a- from the door lining.

Dimension -a- = 0 to - 1 mm.



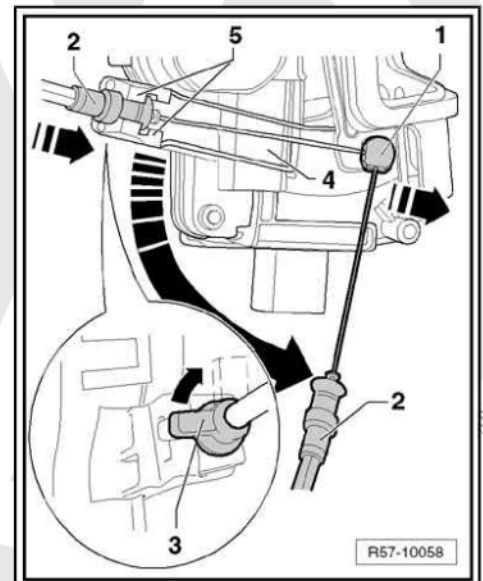
1.16 Lock Bowden cable - replace

Removal:

- Remove the door lock ⇒ [page 53](#) .
- Turn lock -3- on the cable cover by 90°
- Disengage the cable from locks -5- and move the cable -2- by 90° to align the cable fastener -1- with the grooves on the lock lever and remove it.
- Disengage and remove the cable.

Installation:

- Installation is performed in the reverse sequence to the removal.



1.17 Door sealing membrane - remove and install



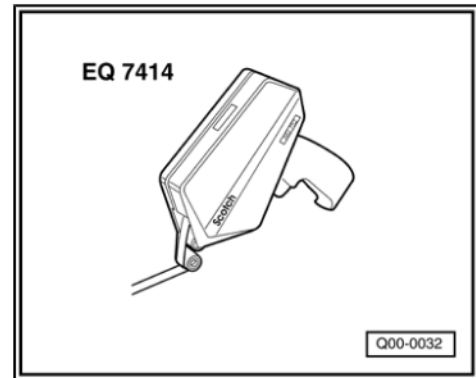
WARNING

- ◆ When handling chemicals follow the safety instructions ⇒ Chemical Products Manual; Rep. gr. 00
- ◆ Assignment of Chemical Materials ⇒ Electronic Parts Catalogue "ETKA"

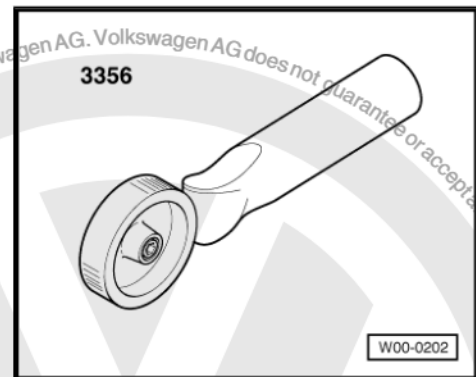
Special tools and workshop equipment required



◆ Transferable adhesive tape applicator - EQ 7414-



◆ Pressure roll - 3356-

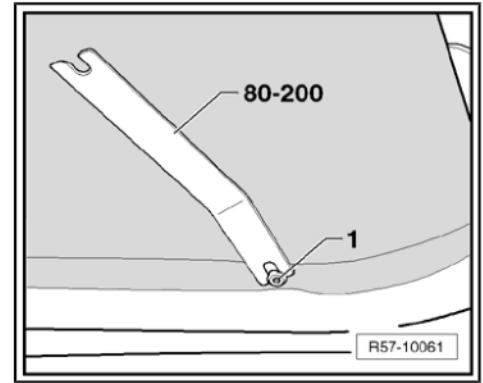


Removal:

- Remove the door lining ⇒ General body repairs, interior; Rep. gr. 70 ; Lining / insulation - Door linings - remove and install .



- Remove the adhesive tapes that fasten the membrane to the lock operating cable and wiring harnesses.
- Remove bushings -1- with the ejector lever - 80-200- .
- Remove and install ⇒ Communication; Rep. gr. 91 ; Radio, telephone, navigation system .
- Detach the sealing membrane and remove it.
- Remove any remaining adhesive from the internal door panel using the cleaning solution - D 009 401 04- .



i Note

Moisten a cloth with the cleaning solution - D 009 401 04- and gently apply it over the affected area. Allow the product to work for a moment and then rub towards the centre starting from the edges. Repeat the operation if necessary. Next, rub the surface with a cloth until it is completely dry.

Installation:

Installation is performed in reverse to the removal sequence, observing the following:

i Note

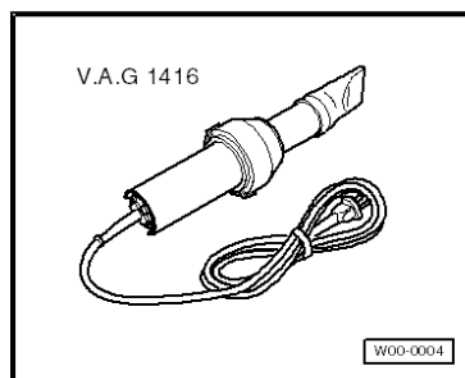
- ◆ *0,2 ± 0,02 mm thick Polypropylene film. Adhesive strength ≥ 4 N/cm.*
- ◆ *The membrane may be reinstalled if there is no damage such as stretching or wrinkles which can fatally compromise the seal against water and dust.*
- ◆ *The membrane has an sensitive acrylate-based adhesive coating that ensures it can be removed up to 3 times without affecting the adhesive performance. If the adhesive coating is damaged, that is, removed by the fourth time, install the membrane by using transferable adhesive tape ⇒ Chemicals Manual as indicated below.*
- ◆ *Apply transferable adhesive tape ⇒ Chemicals Manual to the internal door panel (membrane adhesion area) with the transferable adhesive tape applicator - EQ 7414- , in case of loss of membrane adherence.*
- Install the membrane by passing the cable and harnesses through the holes and paste it to the internal door panel.
- Press the door sealing membrane with the pressure roll - 3356- .
- Fasten the sealing membrane to the lock operating cable and wiring harnesses.
- Install the door lining ⇒ General body repairs, interior; Rep. gr. 70 ; Lining / insulation - Door linings - remove and install .

1.18 Door sealing packings - Assembly overview

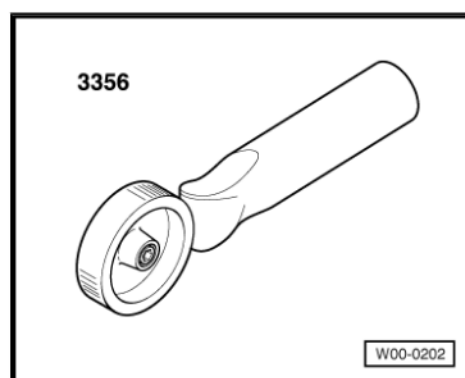
Special tools and workshop equipment required



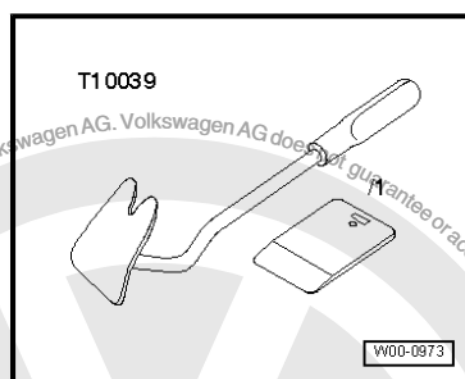
◆ Hot air blower - VAG 1416-



◆ Pressure roll - 3356-



◆ Wedge - T 10039/1-





1 - Double-sided tape

- ☐ The adhesive tape adhesion area must be completely free of dirt.
- ☐ Under no circumstances should the self-adhesive surface of the tape be touched.
- ☐ When assembling a new external packing, remove double-sided tape liner.

2 - External door trim

- ☐ self-adhesive
- ☐ Remove and install
⇒ [page 59](#)

3 - Internal lid trim

- ☐ Covered on lower section by threshold trim.
- ☐ Remove and install
⇒ [page 60](#)

4 - Threshold trim

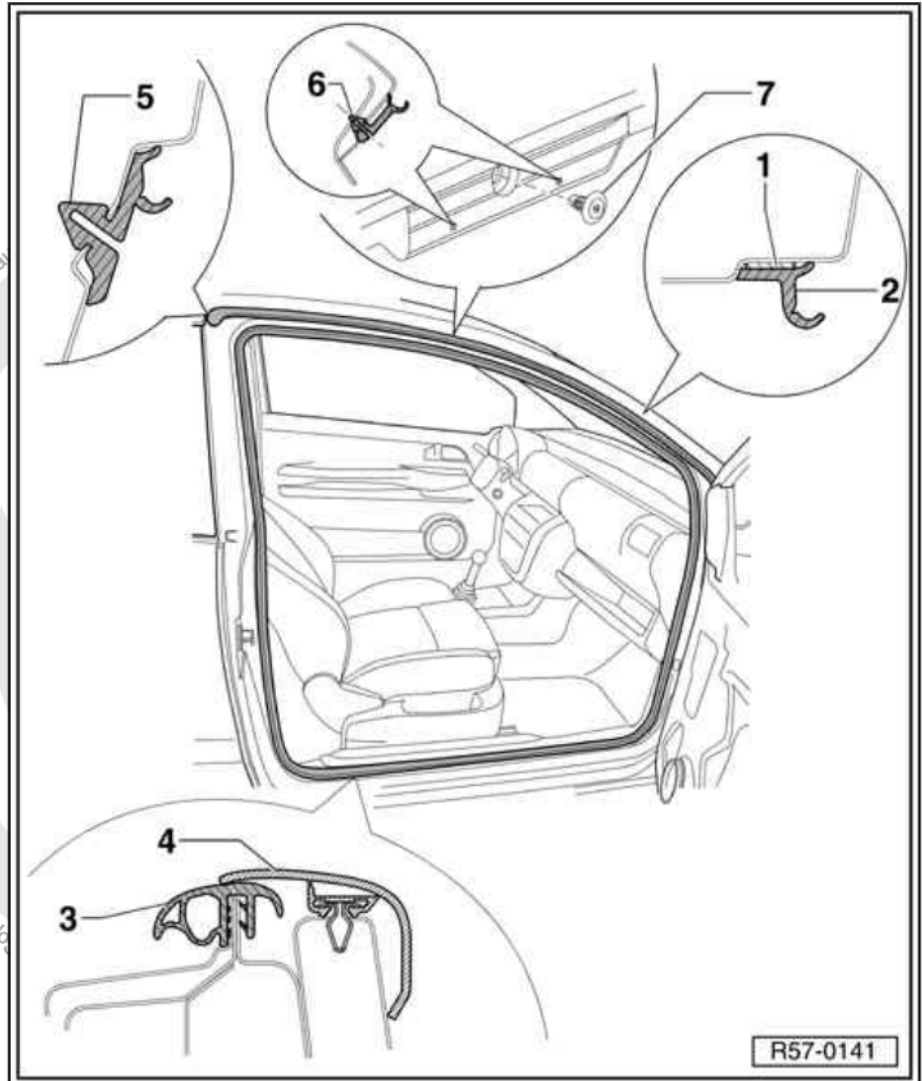
- ☐ Remove and install ⇒
General body repairs,
interior; Rep. gr. 68 ; In-
ternal equipment

5 - Door external packing fitting (rear section)

6 - Door external packing fitting (rack area)

7 - Pin

- ☐ Threaded



1.19 External door packing - remove and install



WARNING

- ◆ When handling chemicals follow the safety instructions ⇒
Chemical Products Manual; Rep. gr. 00
- ◆ Assignment of Chemical Materials ⇒ Electronic Parts
Catalogue "ETKA"

Removal:

- Remove fastening pin -7-.

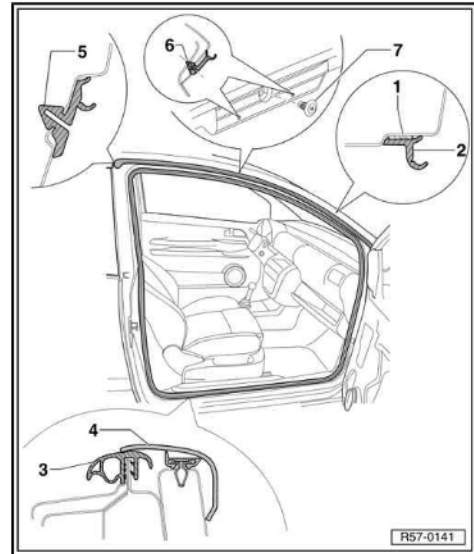


- Heat up trim with the hot air blower - VAG 1416- .
- Detach trim using wedge - T 10039/1- .

Installation:

Installation is performed in reverse to the removal sequence, observing the following:

- Clean door frame in the adhesion area with adhesive remover - D 002 000 A2- , then apply cleaning solution - D 009 401 04- . Dry the section with a dry cloth.
- Heat up the trim adhesive tape and door frame in the assembly section with the hot air blower - VAG 1416- at a temperature of 30 - 40 °C.
- Press packing -6- fitting and then press packing -5- fitting onto door frame holes.
- Remove the double-sided tape liner -1- and glue trim by firmly pressing it (above 10 N) with a pressure roll - 3356- . Only move the pressure roll in one direction.



Note

Do not move it back and forth.

- Install pin -7-.



Note

After assemble, the door must be kept open for a minimum period of 30 minutes so that the door's pressure on packing do not lead to premature packing detaching.

1.20 Internal door trim - remove and install

Removal:

- Remove front door threshold trim ⇒ General body repairs, interior; Rep. gr. 68 ; Internal Equipment .
- Disengage and remove the trim.

Installation:



Note

- ♦ *The vulcanized splice of the packing shall be mounted at the same height of the lock operating lever in the bonnet -arrow A-.*
- ♦ *For partially removed trim, it is necessary to press the trim sides -arrow- before assembly.*



- Manually engage the trim, initially in the door crest, and engage the remaining trim spots distributing trim tension.
- Slightly press the trim with a rubber hammer.
- Install front door threshold trim ⇒ General body repairs, interior; Rep. gr. 68 ; Internal Equipment .

1.21 Cylinders and keys (Specific information for Brazil) - request

The key may be requested to the parts department with the original key mechanical code. For this purpose, follow the instructions in the Parts Circular Letter, number 156, of June 2004.

Full cylinders may be requested via fax number (5511) 4347-3652, by sending every information about the vehicle (chassis number, original key mechanical code, etc.)



2 Central locking

2.1 Central locking installation location overview - 2-door Fox

1 - Alarm system horn - H8-

- ❑ Location: on the right side in the engine compartment.

2 - Connection

- ❑ Location: A-pillar
- ❑ Loosen the harness passage hood and disconnect connectors.

3 - Front passenger side window regulator motor - V148-

- ❑ Remove:
 - Remove the door lining ⇒ General body repairs, interior; Rep. gr. 70 ; Lining / insulation
 - Remove window activation motor ⇒ [page 151](#) .

4 - Right front door lock

- ❑ Central locking system motor for passenger door - V303- integrated to lock.
- ❑ Remove:
 - Remove the door lining ⇒ General body repairs, interior; Rep. gr. 70 ; Lining / insulation
 - Remove the door lock ⇒ [page 53](#) .

5 - Rear lid unlocking motor - V139-

- ❑ Fastened to bonnet support
- ❑ Remove and install ⇒ [page 26](#)

6 - Connection

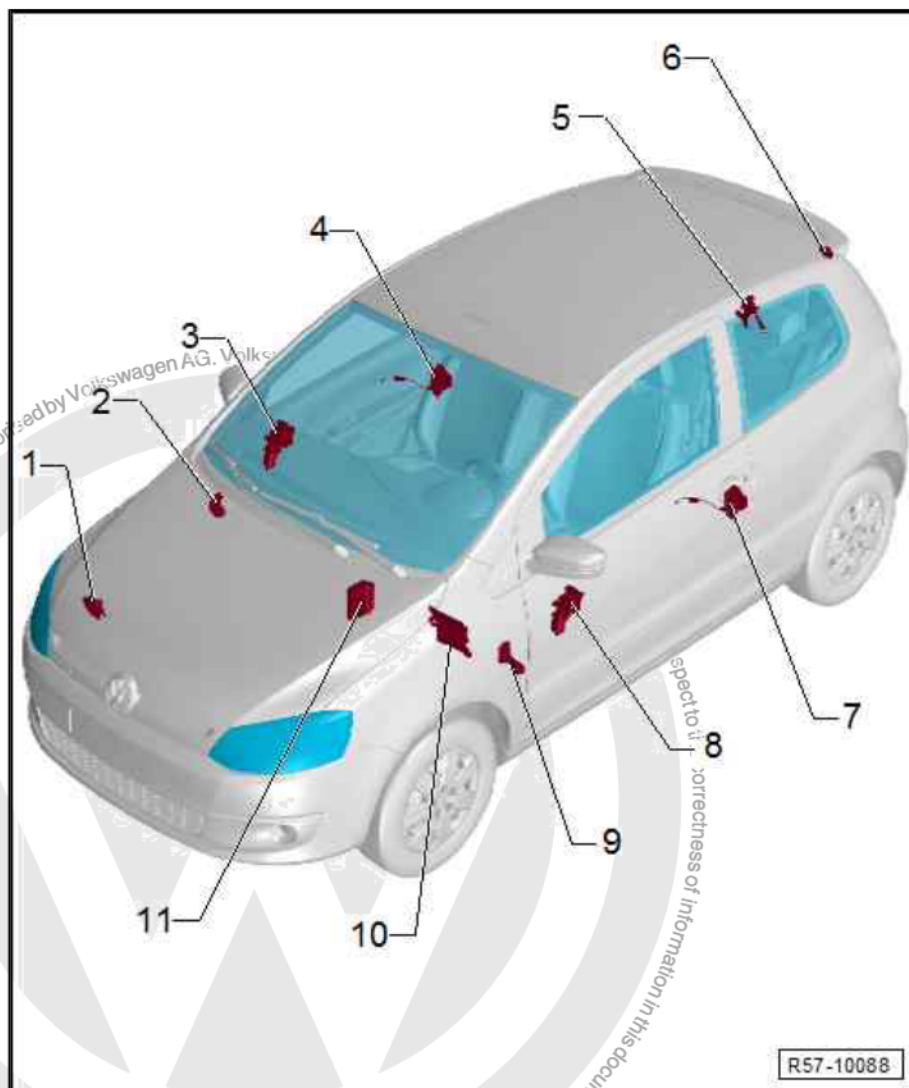
- ❑ Location: upper part of the rear lid.

7 - Left front door lock

- ❑ Central locking system motor for driver door - V302- integrated to lock.
- ❑ Remove:
 - Remove the door lining ⇒ General body repairs, interior; Rep. gr. 70 ; Lining / insulation
 - Remove the door lock ⇒ [page 53](#) .

8 - Driver side window regulator motor - V147-

- ❑ Remove:
 - Remove the door lining ⇒ General body repairs, interior; Rep. gr. 70 ; Lining / insulation
 - Remove window activation motor .





9 - Connection

- ☐ Location: A-pillar
- ☐ Loosen the harness passage hood and disconnect connectors.

10 - On-board supply control unit - J519-

- ☐ Installed behind the electric central.
- ☐ ⇒ Electrical equipment; Rep. gr. 97 ; Electrical cables, harnesses / cables set

11 - Central control unit for convenience system - J393- / Central control unit for glass command - J1015-

- ☐ Convenience system central control unit - J393- ► 2013
- ☐ Windows central control unit - J1015- 2014 ►
- ☐ Assembled in a support in the central dashboard support
- ☐ Location: below dashboard at driver's side, and above the accelerator pedal (in vehicles with steering wheel at the right, above the clutch pedal).
- ☐ Remove and install ⇒ [page 67](#)

2.2 Central locking installation location overview - 4-door Fox

1 - Alarm system horn - H8-

- ☐ Location: on the right side in the engine compartment.

2 - Connection

- ☐ Location: A-pillar
- ☐ Loosen the harness passage hood and disconnect connectors.

3 - Front passenger side window regulator motor - V148-

- ☐ Remove the door lining ⇒ General body repairs, interior; Rep. gr. 70 ; Lining / insulation .
- ☐ Remove window activation motor ⇒ [page 151](#) .

4 - Right front door lock

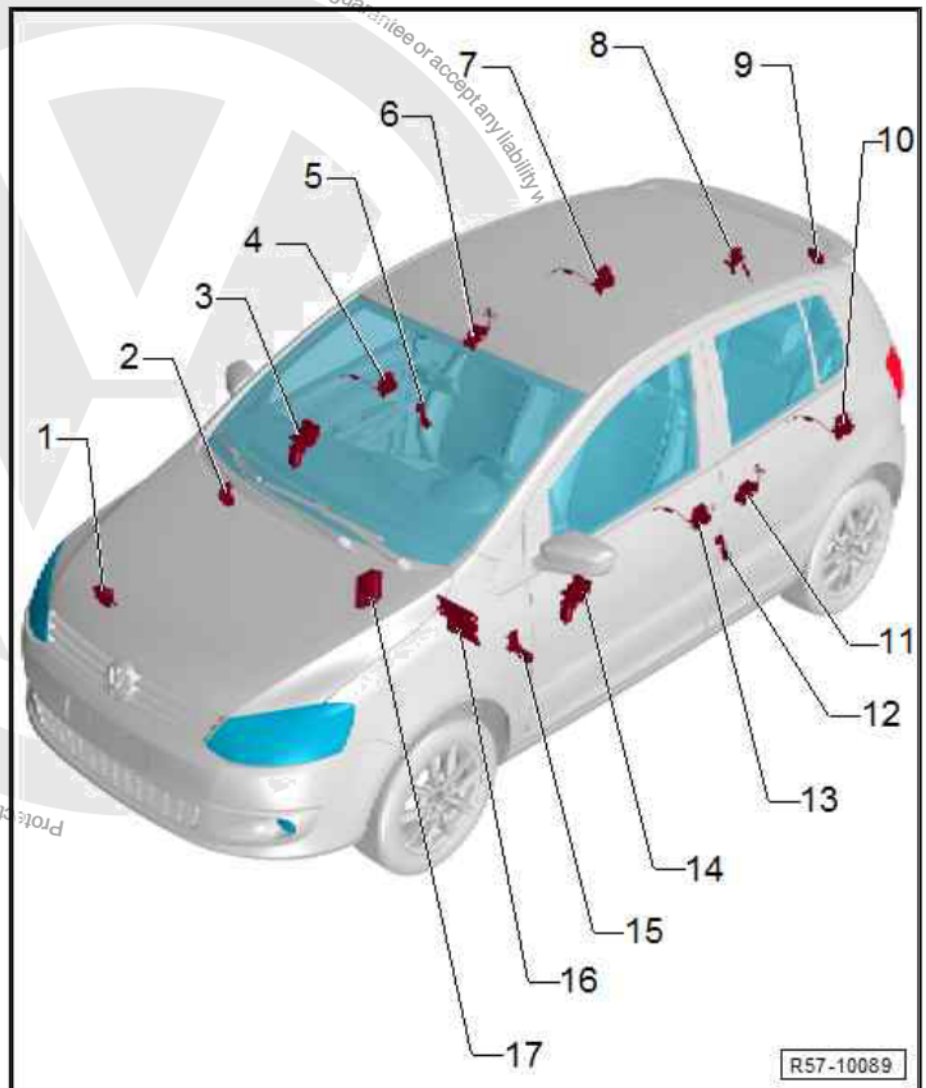
- ☐ Remove the door lining ⇒ General body repairs, interior; Rep. gr. 70 ; Lining / insulation .
- ☐ Remove the door lock ⇒ [page 53](#) .

5 - Connection

- ☐ Location: B-pillar
- ☐ Loosen the harness passage hood and disconnect connectors.

6 - Rear right window regulator motor - V27-

- ☐ Door control unit in vehicles with convenience system
- ☐ Integrated to the window drive motor
- ☐ Remove the door lining ⇒ General body repairs, interior; Rep. gr. 70 ; Lining / insulation
- ☐ Remove Rear right window regulator motor - V27-





- 7 - Right rear door lock
- ☐ The electric central locking is integrated to the door lock module
 - ☐ Remove the door lining ⇒ General body repairs, interior; Rep. gr. 70 ; Lining / insulation
- 8 - Rear lid unlocking motor - V139-
- ☐ Installed on a rear door support
 - ☐ Remove and install ⇒ [page 26](#)
- 9 - Connection
- ☐ Location: upper part of the rear lid.
- 10 - Left rear door lock
- ☐ The electric central locking is integrated to the door lock module
 - ☐ Remove the door lining ⇒ General body repairs, interior; Rep. gr. 70 ; Lining / insulation
 - ☐ Remove the door lock ⇒ [page 82](#)
- 11 - Rear left window regulator motor - V26-
- ☐ Integrated to the window drive motor
 - ☐ Remove the door lining ⇒ General body repairs, interior; Rep. gr. 70 ; Lining / insulation
 - ☐ Remove the window activation motor ⇒ [page 156](#)
- 12 - Connection
- ☐ Location: B-pillar.
 - ☐ Loosen the harness passage hood and disconnect connectors.
- 13 - Left front door lock
- ☐ The electric central locking is integrated to the door lock module.
 - ☐ Remove the door lining ⇒ General body repairs, interior; Rep. gr. 70 ; Lining / insulation
 - ☐ Remove the door lock ⇒ [page 53](#) .
- 14 - Driver side window regulator motor - V147-
- ☐ Door control unit in vehicles with convenience system.
 - ☐ Integrated to the window drive motor.
 - ☐ Remove the door lining ⇒ General body repairs, interior; Rep. gr. 70 ; Lining / insulation
 - ☐ Remove the window activation motor ⇒ [page 156](#)
- 15 - Connection
- ☐ Location: A-pillar
 - ☐ Loosen the harness passage hood and disconnect connectors.
- 16 - On-board supply control unit - J519-
- ☐ Installed behind the electric central.
 - ☐ ⇒ Electrical equipment; Rep. gr. 97 ; Electrical cables, harnesses / cables set
- 17 - Central control unit for convenience system - J393- / Central control unit for glass command - J1015-
- ☐ Convenience system central control unit - J393- ► 2013
 - ☐ Windows central control unit - J1015- 2014 ►
 - ☐ Assembled in a support in the central dashboard support
 - ☐ Location: below dashboard at driver's side, and above the accelerator pedal (in vehicles with steering wheel at the right, above the clutch pedal).
 - ☐ Remove and install ⇒ [page 67](#)

2.3 Central locking - Spacefox / Suran - assembly locations overview

1 - Alarm system horn - H8-

- ☐ Location: on the right side of the engine compartment

2 - Connection

- ☐ Location: on the right side in the engine compartment
- ☐ Location: A-pillar
- ☐ Loosen the harness passage hood and disconnect connectors.

3 - Front passenger side window regulator motor - V148-

- ☐ Remove the door lining
⇒ General body repairs, interior; Rep. gr. 70 ; Lining / insulation - Door linings - remove and install .
- ☐ Remove window activation motor ⇒ [page 151](#) .

4 - Right front door lock

- ☐ Remove the door lining
⇒ General body repairs, interior; Rep. gr. 70 ; Lining / insulation - Door linings - remove and install .
- ☐ Remove the door lock
⇒ [page 53](#) .

5 - Connection

- ☐ Location: B-pillar
- ☐ Loosen the harness passage hood and disconnect connectors.

6 - Rear right window regulator motor - V27-

- ☐ Door control unit in vehicles with convenience system.
- ☐ Integrated to the window drive motor.
- ☐ Remove the door lining ⇒ General body repairs, interior; Rep. gr. 70 ; Lining / insulation - Door linings - remove and install .
- ☐ Remove Rear right window regulator motor - V27-

7 - Right rear door lock

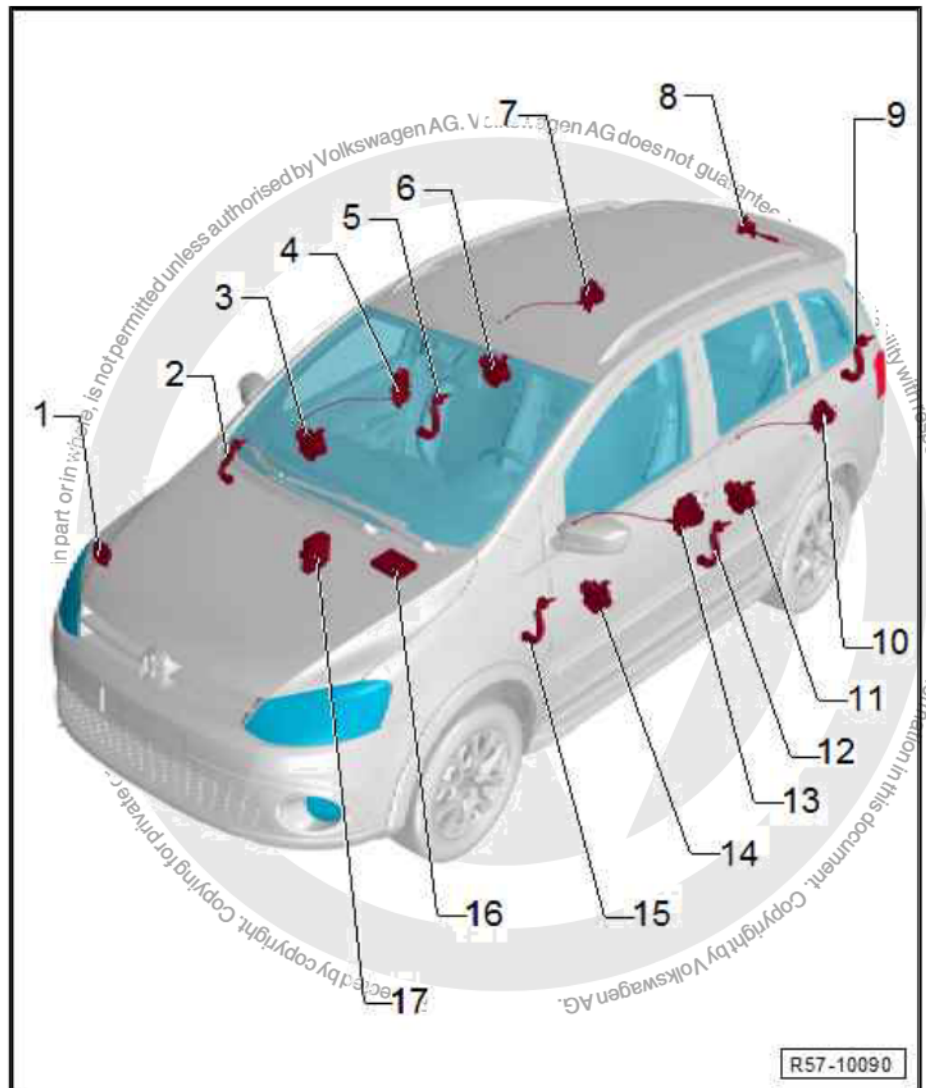
- ☐ The electric central locking is integrated to the door lock module.
- ☐ Remove the door lining ⇒ General body repairs, interior; Rep. gr. 70 ; Lining / insulation - Door linings - remove and install .

8 - Rear lid unlocking motor - V139-

- ☐ Installed on a rear door support
- ☐ Remove and install ⇒ [page 34](#)

9 - Connection

- ☐ Location: upper area of D-pillar





10 - Left rear door lock

- ☐ The electric central locking is integrated to the door lock module.
- ☐ Remove the door lining ⇒ General body repairs, interior; Rep. gr. 70 ; Lining / insulation - Door linings - remove and install .
- ☐ Remove the door lock ⇒ [page 82](#) .

11 - Rear left window regulator motor - V26-

- ☐ Integrated to the window drive motor.
- ☐ Remove the door lining ⇒ General body repairs, interior; Rep. gr. 70 ; Lining / insulation - Door linings - remove and install .
- ☐ Remove the window activation motor ⇒ [page 156](#)

12 - Connection

- ☐ Location: B-pillar
- ☐ Loosen the harness passage hood and disconnect connectors.

13 - Left front door lock

- ☐ The electric central locking is integrated to the door lock module.
- ☐ Remove the door lining ⇒ General body repairs, interior; Rep. gr. 70 ; Lining / insulation - Door linings - remove and install .
- ☐ Remove the door lock ⇒ [page 53](#) .

14 - Driver side window regulator motor - V147-

- ☐ Door control unit in vehicles with convenience system
- ☐ Integrated to the window drive motor
- ☐ Remove the door lining ⇒ General body repairs, interior; Rep. gr. 70 ; Lining / insulation - Door linings - remove and install .
- ☐ Remove the window activation motor ⇒ [page 151](#)

15 - Command unit

- ☐ Installed on door lining
- ☐ Remove the door lining ⇒ General body repairs, interior; Rep. gr. 70 ; Lining / insulation - Door linings - remove and install .

16 - Connection

- ☐ Location: A-pillar
- ☐ Loosen the harness passage hood and disconnect connectors.

17 - On-board supply control unit - J519-

- ☐ Installed behind the electric central.
- ☐ ⇒ Electrical equipment; Rep. gr. 97 ; Electrical cables, harnesses / cables set

18 - Central control unit for convenience system - J393- / Central control unit for glass command - J1015-

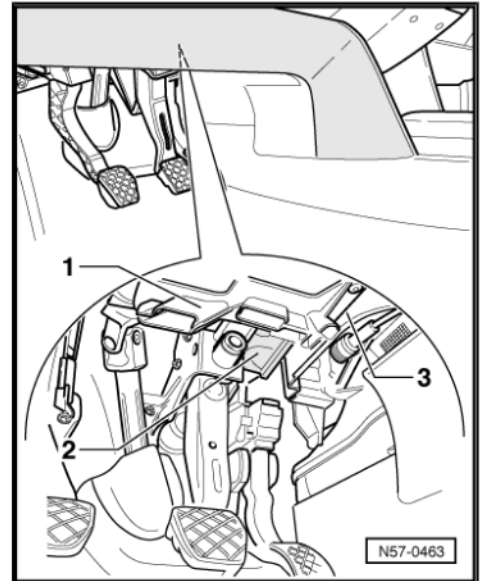
- ☐ Convenience system central control unit - J393- ► 2013
- ☐ Windows central control unit - J1015- 2014 ►
- ☐ Assembled in a support in the central dashboard support
- ☐ Location: below dashboard at driver's side, and above the accelerator pedal (in vehicles with steering wheel at the right, above the clutch pedal).
- ☐ Remove and install ⇒ [page 67](#)



2.4 Central control unit for convenience system -J393- / Central control unit for glass command -J1015- - remove

The command unit for convenience system -2- is located on a plastic support installed on the dashboard central support -3-.

- Remove the baffle -1- for the foot area on the driver's side ⇒ Heating, air conditioner; Rep. gr. 80 ; Heating .

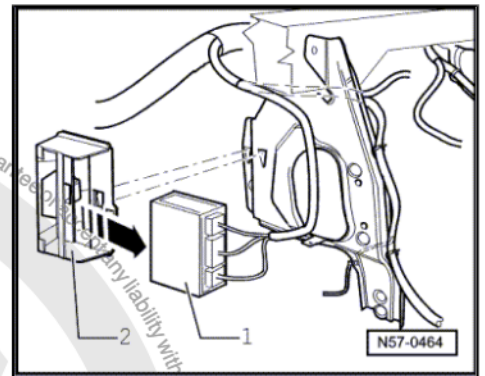


- Pull -arrow- the command unit for convenience system - J393- -1- out of support -2- and disconnect connector.



Note

- ◆ When the command unit for convenience system - J393- is replaced, it is necessary to codify the new unit, adapt the radio-commanded keys ⇒ [page 69](#) , and enable/disable available functions.
- ◆ Vehicle diagnostic, testing and information system - VAS 5051- , Vehicle diagnostic, testing and information system - VAS 5052- , Vehicle diagnostic, testing and information system - VAS 6150- , Diagnostic cable - VAS 5051/6B- and Diagnostic cable - VAS 5052/3A- and Wireless diagnostic connector - VAS 5054A-



2.5 Battery of key with radio remote command (articulated) - assembly overview



1 - Radio-remote command key

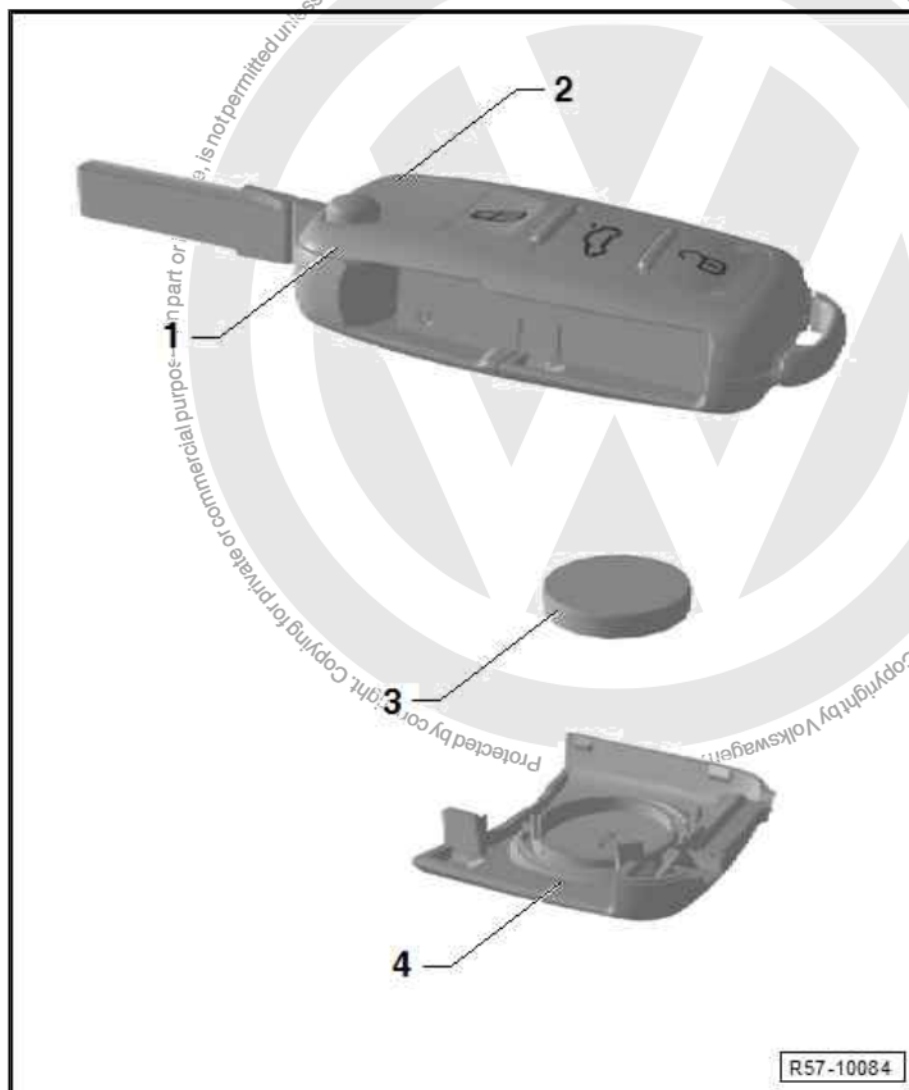
2 - Light indicator (LED)

- ☐ The indicator lamp must blink when the remote command is activated.
- ☐ If the indicator lamp does not blink when the remote command is activated, the battery is discharged and must be replaced.

3 - Battery

- ☐ Remove and install
⇒ [page 68](#) .

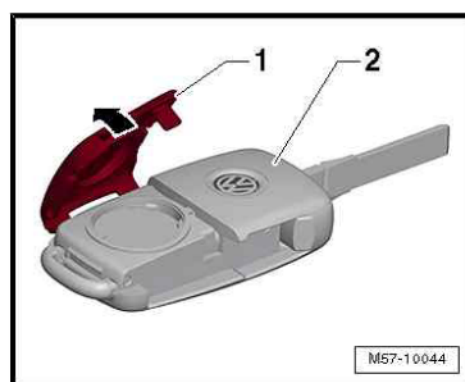
4 - Battery housing cover



2.6 Battery of key with radio remote command (articulated) - remove and install

Removal:

- Unfold key.





- Disconnect the cover -1- from the key battery housing -2- towards the -arrow-.
- Disconnect the battery -1- with an appropriate screwdriver in the direction of the -arrow- to the outside of the key -2-.

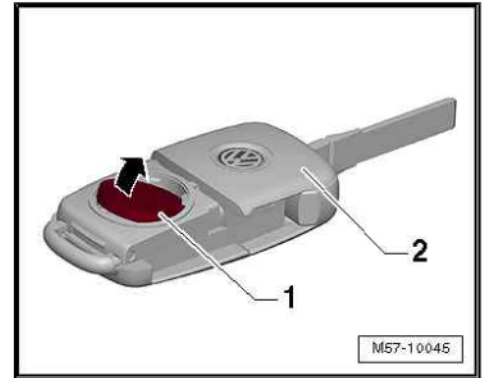
Installation:

Installation is performed in reverse to the removal sequence, observing the following:



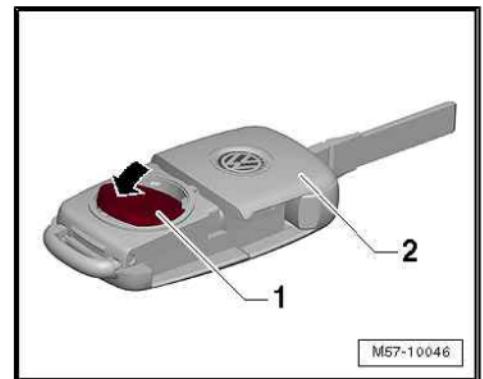
Note

- ◆ *Before installing the battery, it is indispensable to press one of the command keys.*
- ◆ *With this procedure, the command will recognize the new battery.*

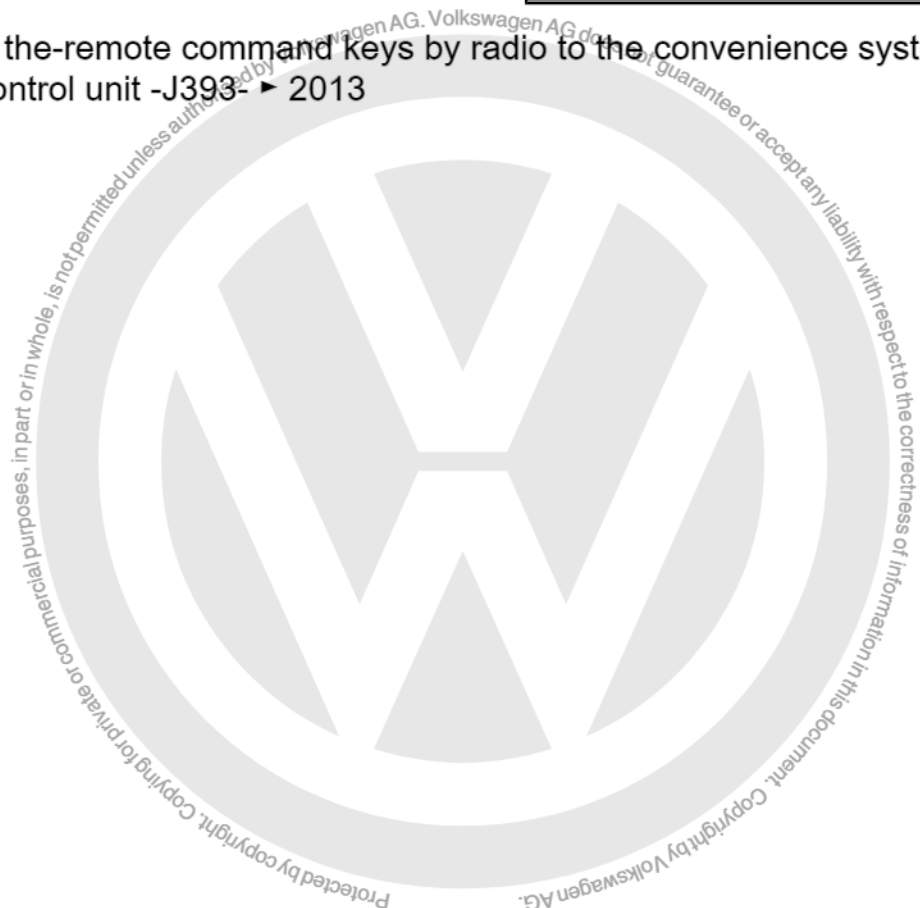


When installing the battery, pay attention to the polarity and the assembly position.

- Put the battery -1- on the radio remote command -2- with the positive pole turned upwards.
- By slightly pressing the battery, it fits to the remote command via radio.
- Fit the radio remote command cover.





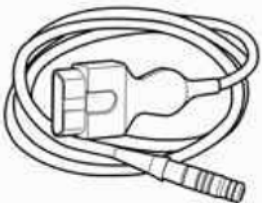



2.7 Adapting the remote command keys by radio to the convenience system central control unit -J393- ➤ 2013





Special tools and workshop
equipment required

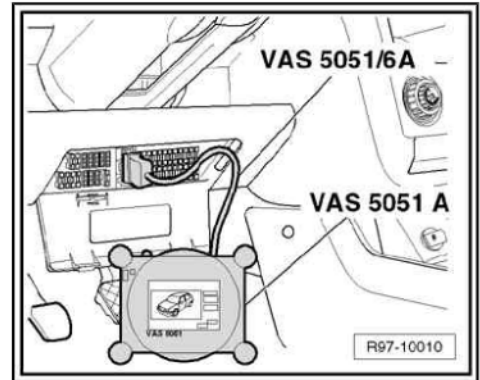
VAS 5051 	VAS 5052 
VAS 6150 	VAS 5051/6B 
VAS 5052/3A 	VAS 5054 A  Q97-10001

- ◆ Vehicle diagnostic testing and information system - VAS 5051-
- ◆ Vehicle diagnostic, testing and information system - VAS 5052-
- ◆ Vehicle diagnostic, testing and information system - VAS 6150-
- ◆ Diagnostic cable - VAS 5051/6B-
- ◆ Diagnostic cable - VAS 5052/3A-
- ◆ Wireless diagnostic connector - VAS 5054A-



Adapting keys with remote control is performed with the Vehicle diagnostic, testing and information system - VAS 5052A / VAS 5051B- .

- Select, in the Vehicle diagnostic, testing and information system - VAS 5052A / VAS 5051B- , the "Assisted troubleshooting".
- Select the "Component selection" function through the Skip key, and sequentially the following menu options:
 - ◆ Body
 - ◆ Body assembly works
 - ◆ 01 - Self-diagnosis systems
 - ◆ Convenience system
 - ◆ Functions - Convenience system
 - ◆ Adapting keys with remote control



Note

For adaptation of radio-commanded keys to the immobilizer control unit - J362- , refer to ⇒ Electrical system; Rep. gr. 96. Switches, lights and internal lamps, alarm - Ignition key - adapt to immobilizer .

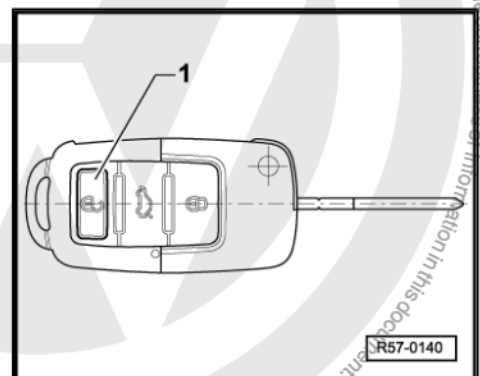
2.8 Key - synchronize

The key synchronization is required when some key is pressed out of the sphere of action of the system.

- Turn the ignition key on by using the backup key.
- Insert the key with remote control into the driver's side door cylinder. Turn it counterclockwise and keep it in this position.
- Press the key -1- repeatedly until achieving the synchronism that will be recognized by the automatic locking and unlocking of the doors.

The Central control unit for convenience system - J393- stores until two synchronizations. In order to perform a third synchronization, it is required to reset the unit through Vehicle diagnostic, testing and information system - VAS 5052A / VAS 5051B- .

- ◆ "46 - Convenience system central module."
- ◆ "Function 10 - Adapting"
- ◆ "Channel 11", reset.





58 – Rear doors, door components

1 Rear passenger doors

1.1 Rear passenger doors - assembly overview



WARNING

- ◆ When handling chemicals follow the safety instructions ⇒ *Chemical Products Manual; Rep. gr. 00*
- ◆ Assignment of Chemical Materials ⇒ *Electronic Parts Catalogue "ETKA"*

1 - External handle

- Remove and install
⇒ [page 78](#)

2 - Cylinder housing without lock cylinder

- Remove and install
⇒ [page 79](#)

3 - Cover cap

4 - Locking button

- In 2013 ► models, versions with electric locking do not have this button.
- Installed on the locking rod up to the buffer
- Position in relation to door lining ⇒ [page 84](#)

5 - Locking rod

- In 2013 ► models, versions with electric locking do not have this rod.

6 - Eyelet

- In 2013 ► models, versions with electric locking do not have this eye.

7 - Bushing

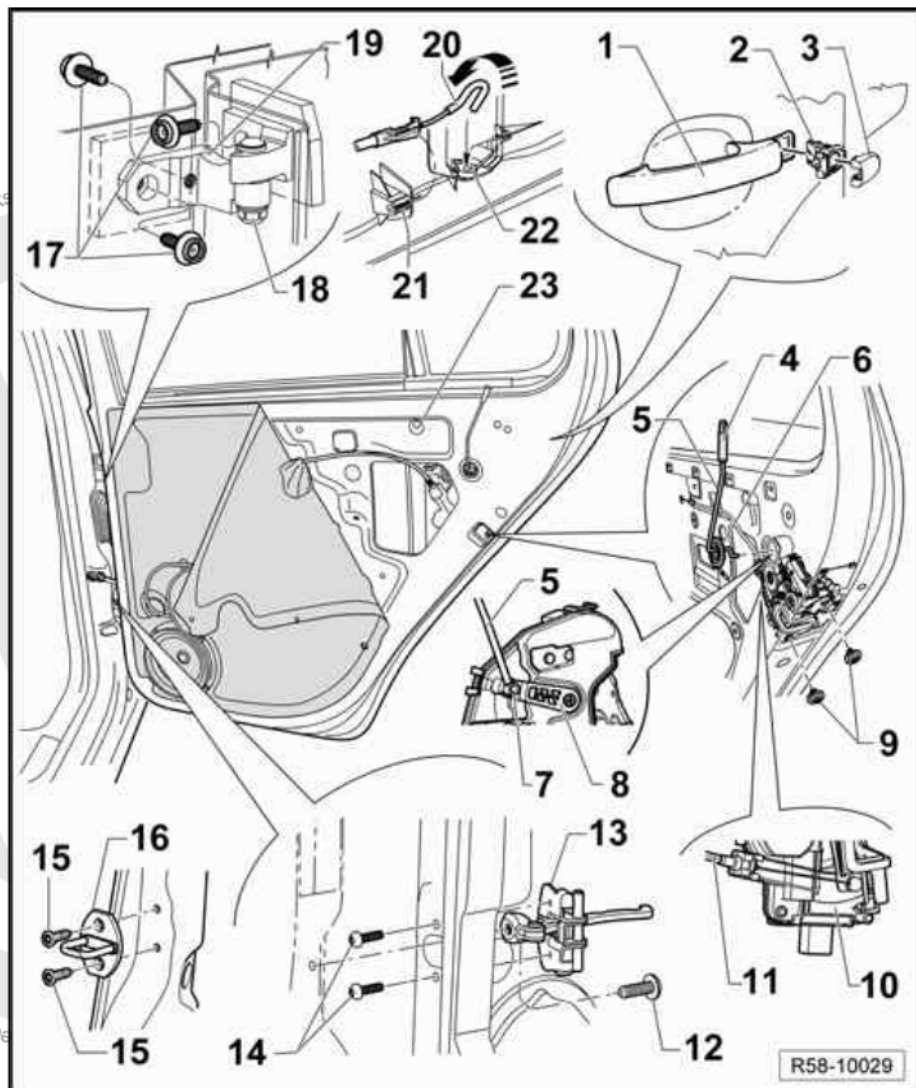
- replace if necessary
- In 2013 ► models, versions with electric locking do not have this bushing.

8 - Lock actuating lever

- In 2013 ► models, versions with electric locking do not have this lever.

9 - Bolt

- Torque: 20 Nm





10 - Door lock

- ☐ Remove and install ⇒ [page 82](#)
- ☐ Lubricate with low-temperature grease -G 052 745 A3-
- ☐ The control motor for left/right rear window - V26 / V27- is integrated to the lock set.

11 - Lock Bowden cable

- ☐ Remove and install ⇒ [page 84](#)

12 - Bolt

- ☐ Torque: 25 Nm

13 - Door limiter

- ☐ Remove and install ⇒ [page 77](#)

14 - Bolt

- ☐ Torque: 6 Nm

15 - Bolt

- ☐ Torque: 25 Nm

16 - Door arrester

- ☐ Adjust ⇒ [page 76](#)

17 - Bolts

- ☐ M 8
- ☐ Torque: 20 Nm + 1/4 (90°)
- ☐ They must be replaced whenever loosen or removed

18 - Nut

- ☐ Torque: 14 Nm

19 - Door hinge

- ☐ In two sections

20 - Lock Bowden cable hook

21 - Cable support

- ☐ On the door lining

22 - Interior handle

23 - Door

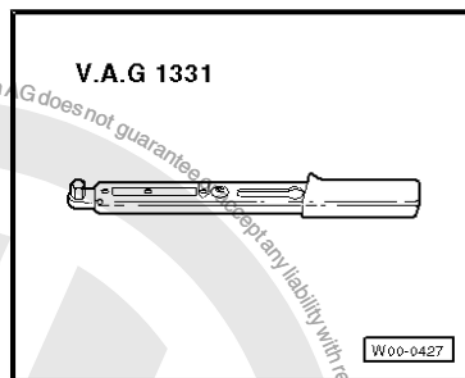
- ☐ Remove and install ⇒ [page 73](#)
- ☐ Adjust ⇒ [page 74](#)
- ☐ Disassemble and assemble ⇒ [page 76](#)
- ☐ Replace ⇒ [page 76](#)

1.2 Rear passenger door - remove and install

Special tools and workshop equipment required



- ◆ Torque wrench - 5 to 50 Nm (1/2" drive) - VAG 1331-



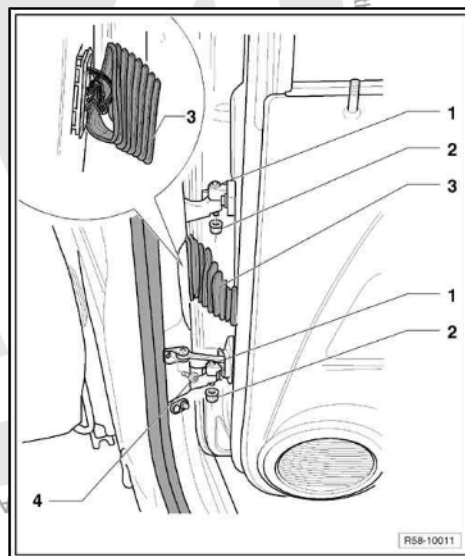
Removal:

- Pull protection bellows -3- from B-pillar and disconnect electric connections of connector located on B-pillar.
- Remove nuts -2- from hinge pins -1-.
- Remove the screw -4- from the door limiter.
- Disengage door upward and out of hinge angle bars.

Installation:

Install is performed in the reverse sequence, observing the following:

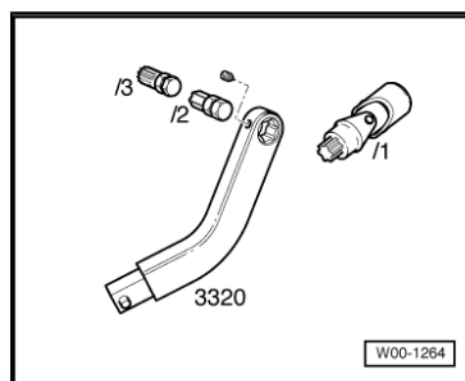
- Tighten the nuts -2- of the hinge pins to a torque of: 14 Nm.
- Tighten the screw -4- of the door limiter to a torque of: 25 Nm.



1.3 Rear passenger door - adjust

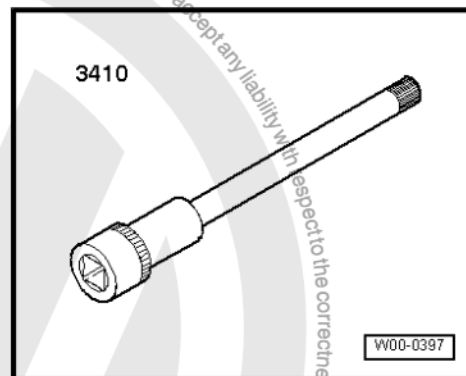
Special tools and workshop equipment required

- ◆ Wrench - 3320-
- ◆ Multi-tooth bits - 3320/3-

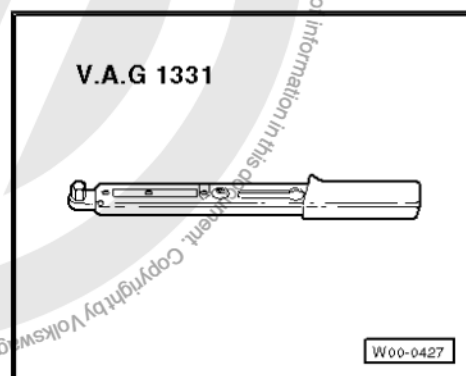




- ◆ Multi-teeth socket - 3410-



- ◆ Torque wrench - 5 to 50Nm (1/2" drive) - VAG 1331-



Note

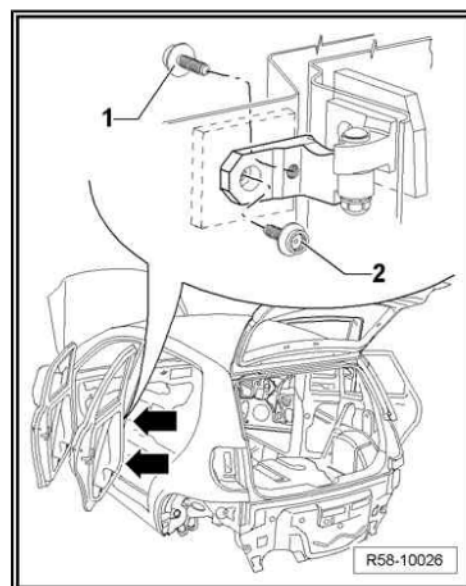
- ◆ *Vehicle must be supported by its wheels in order to correctly adjust the front door.*
- ◆ *The front door is correctly adjust when clearances are as specified ⇒ Body Repairs; Rep. gr. 00 ; Technical data - Body clearance dimensions when door is locked.*
- ◆ *Take anticorrosion protection measures on hinges and screws after reinstalling or adjusting.*

Screws -1- and -2- must be loosened on the A-pillar to correctly adjust the clearances.

- For screw -1- on the lower door hinge, the lower B-pillar lining must be removed: ⇒ General body repairs, interior; Rep. gr. 70 ; Lining/insulation . Loosen screw with multi-tooth socket - 3410- .
- For bolt -1- on the upper door hinge, upper B-pillar lining must be removed: ⇒ General body repairs, interior; Rep. gr. 70 ; Linings / insulations Loosen bolt with multi-tooth socket - 3410- .

For screw -2-, loosen it with wrench - 3320- and the multi-tooth bits - 3320/3- .

Adjust the door arrester ⇒ [page 76](#) .





1.4 Rear passenger door - disassemble and assemble

Disassemble:

- Remove the door lining ⇒ General body repairs, interior; Rep. gr. 70 ; Lining / insulation .
- Remove the door seal ⇒ [page 85](#)
- Remove the door window drive mechanism:
 - Manual drive mechanism ⇒ [page 156](#)
 - Power drive mechanism ⇒ [page 155](#)
- Remove the door window glass ⇒ [page 155](#) .
- Remove the rear door fixed window ⇒ [page 159](#) .
- Remove the internal and external door window glass linings.
- Remove the door window chute.
- Remove the external handle ⇒ [page 80](#) .
- Remove the locking pin rod and the inversion lever.
- Remove the lock ⇒ [page 82](#) .
- Remove the door limiter ⇒ [page 77](#) .
- Disconnect the protection bellows and remove the harness from inside the door.

Assemble:

- Assembly is preformed in the reverse sequence to disassembly.

1.5 Rear door - replace

Removal:

- Disassemble the door ⇒ [page 76](#) .
- Remove the door ⇒ [page 73](#) .

Installation:

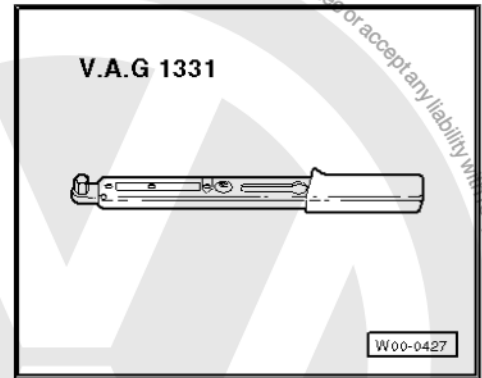
- Apply sealant/caulking to the door⇒ Painting Manual - Body Sealant - Fox .
- Install the door noise insulation ⇒ General body repairs, interior; Rep. gr. 70 ; Lining / insulation .
- Paint the door ⇒ Painting Manual - Repairing paintwork on steel plates and galvanized steel plates.
- Install the door ⇒ [page 73](#) .
- Apply anti-corrosive fluid ⇒ Paint Manual - Application of anti-corrosive fluid - Anti-corrosive fluid .
- Assemble the door ⇒ [page 76](#) .

1.6 Door arrester - adjust

Special tools and workshop equipment required



- ◆ Torque wrench - 5 to 50Nm (1/2" drive) - VAG 1331-



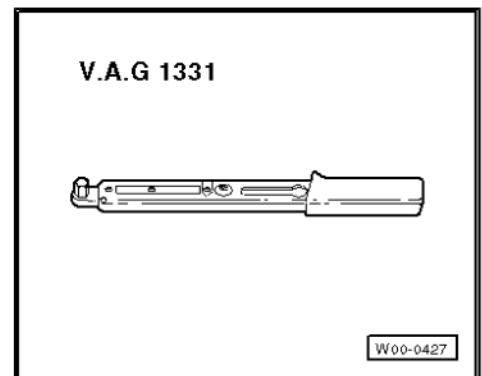
Adjust:

- Loosen buffer fastening screws.
- Position and temporarily tighten the door arrester.
- Close the door and check the alignment with the body, based on the clearance dimensions specified in Body - Repairs; Rep. gr. 00 ; Technical data - Body clearance dimensions .
- Definitely tighten buffer to:
- Torque: 25 Nm (multi-teeth)

1.7 Door limiter - remove and install

Special tools and workshop equipment required

- ◆ Torque wrench - 5 to 50 Nm (1/2" drive) - VAG 1331-

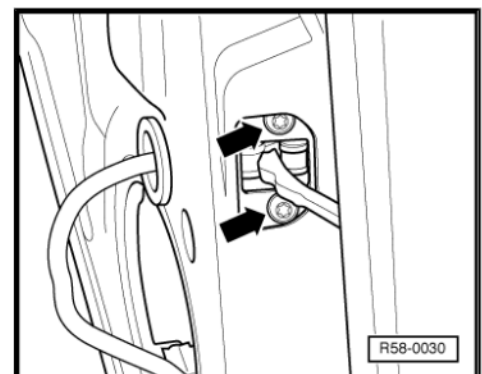


Removal:

- Remove the door lining ⇒ General body repairs, interior; Rep. gr. 70 ; Lining / insulation .
- Partially remove the sealing membrane.
- Remove B-pillar limiter fastening screw (T-40).
- Remove fastening screws -arrows- from door limiter (T-30).
- Remove the limiter from inside the door.

Installation:

- Installation is performed in the reverse sequence to the removal.





1.8 Rear door external handle and lock - assembly overview



WARNING

- ◆ When handling chemicals follow the safety instructions ⇒ *Chemical Products Manual*; Rep. gr. 00
- ◆ Assignment of Chemical Materials ⇒ *Electronic Parts Catalogue "ETKA"*

1 - External handle support

- ❑ Remove the lock cylinder housing ⇒ [page 79](#) .
- ❑ Remove the door handle ⇒ [page 80](#) .
- ❑ Remove the door lining ⇒ *General body repairs, interior*; Rep. gr. 70 ; Lining / insulation .
- ❑ Remove the sealing membrane in the door handle area.
- ❑ Release the screw -4-, push the external handle support a little backwards and remove it from the door.

2 - Bolt

- ❑ Torque: 2.5 Nm

3 - Torx screw

- ❑ Release with the Pincers - T10072- .
- ❑ When releasing the screw, the fastening of the lock cylinder housing is unlocked -7-, and can be pulled out of the external handle support.
- ❑ The screw -2- cannot be tightened without the lock cylinder housing being inserted. The locking ring may fall inside the door.

- ❑ Torque: -Zamak handle support, 4.5 Nm-.
- ❑ Torque: -PA6 30 GF handle support, 2.5 Nm-.

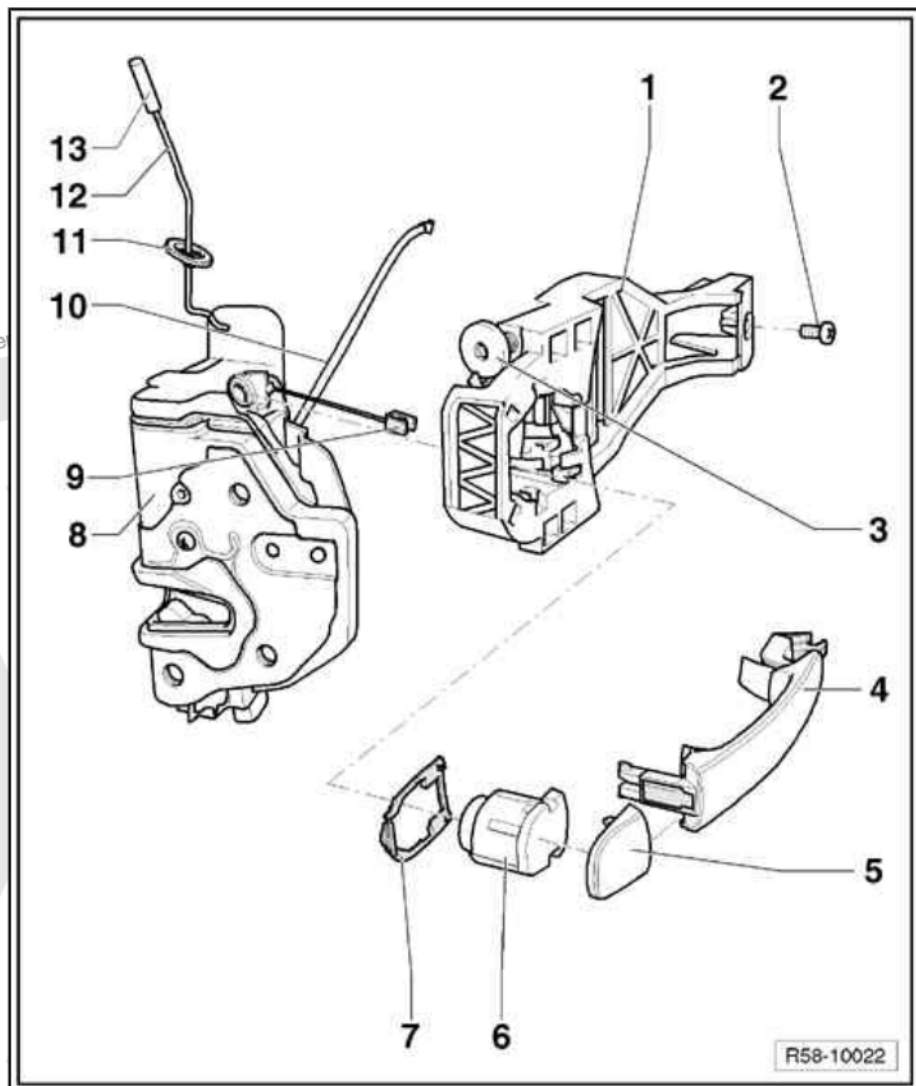
4 - Door handle

- ❑ Remove and install ⇒ [page 80](#)
- ❑ Cover cap

5 - Cover cap

6 - Cylinder housing without lock cylinder

- ❑ Remove and install ⇒ [page 79](#)





7 - Sealing

8 - Door lock

- ☐ Remove and install ⇒ [page 82](#)
- ☐ Lubricate with low-temperature grease - G 052 745 A3- .

9 - Operating cable

- ☐ Lock unlocking.

10 - Lock Bowden cable

- ☐ Remove and install ⇒ [page 84](#)

11 - Eyelet

- ☐ In 2013 ► models, versions with electric locking do not have this eye.

12 - Door lock rod

- ☐ In 2013 ► models, versions with electric locking do not have this rod.

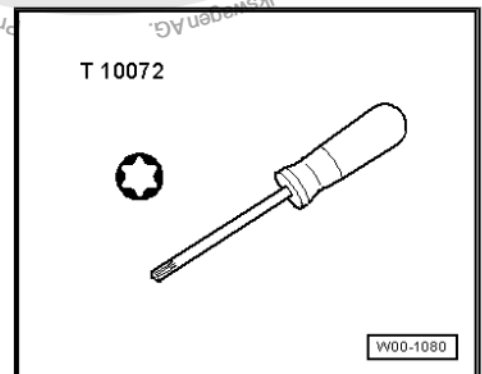
13 - Door lock button

- ☐ In 2013 ► models, versions with electric locking do not have this button.
- ☐ Installed on the locking rod up to the buffer
- ☐ Position in relation to door lining ⇒ [page 84](#)

1.9 Cylinder housing without lock cylinder - remove and install

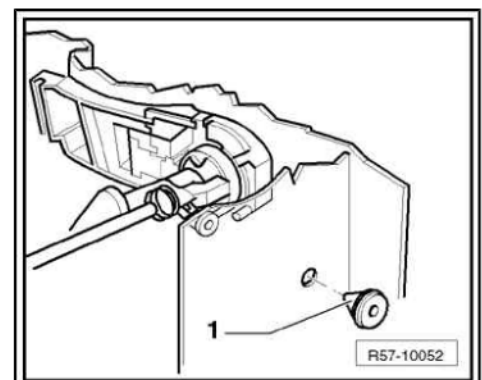
Special tools and workshop equipment required

- ◆ torque wrench - T10072-



Removal:

- Disengage plug -1-.





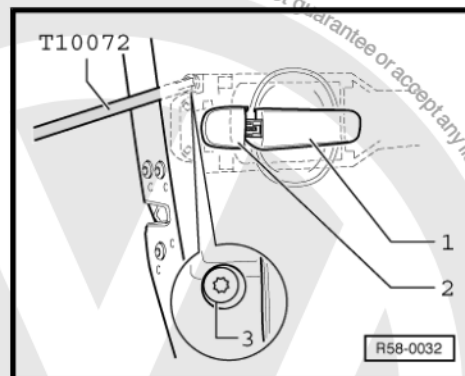
- Pull and hold the door handle -1-. Loosen the screw -3- with the pincers - T10072- and simultaneously press towards the external handle support. This releases the locking in the lock cylinder housing.



Note

If the screw is excessively released, the locking ring may detach from the external handle support and fall into the door as a result.

- Pull the lock cylinder housing -2- out of the external handle support, at a straight angle in relation to the door handle.



Installation:

Install is performed in the reverse sequence, observing the following:

- Place the lock cylinder housing on the external handle support at a straight angle.
- Then, tighten the screw to the external handle support with pincers - T10072- .

The door handle is again fitted to the lock cylinder housing when there is an audible click.



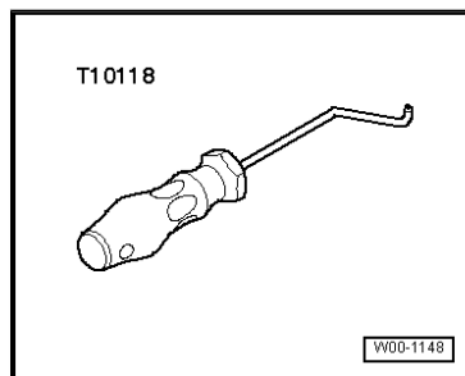
Note

During the assembly, you must press the door handle and the lock cylinder housing against the door plate.

1.10 External door handle - remove and install

Special tools and workshop equipment required

- ◆ Hook - T10118-



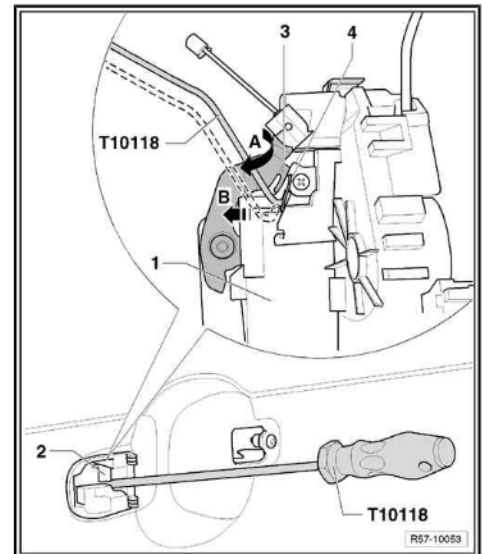
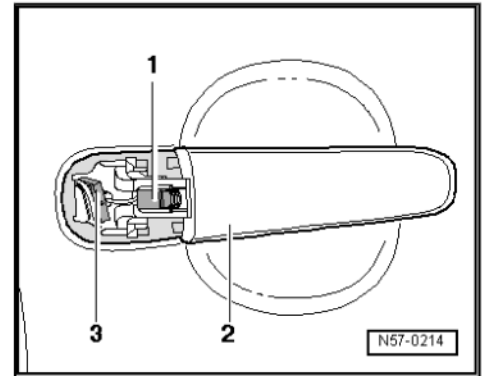


Removal:

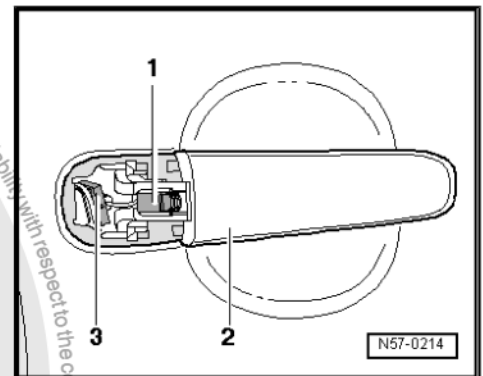
- Remove the lock cylinder housing ➔ [page 79](#) .
- Disengage the clip -1- from the door handle -2-.
- Disengage the door handle -2- from the door panel.

Installation:

- Through the opening on the door panel -1-, insert the hook - T 10118- in the door.
- For better vision, light the door internal section with a lamp.
- Turn the hook - T 10118- on the spring -4- -arrow A-.



- Pull the hook - T 10118- towards -arrow B-, fasten the spring on lever -3- in the door lock -1-.
- Fit the door handle -2- to the door panel.
- Pull the clip -1- inside the plate cut and fit to the door handle.



Note

When assembling the clip, the latch operating lever -3- cannot be pulled and the door handle -2- must be pressed against the door panel.

- Install the lock cylinder housing.

1.11 External door handle - replace

Removal:

- Remove the external handle ➔ [page 80](#) .

Installation:

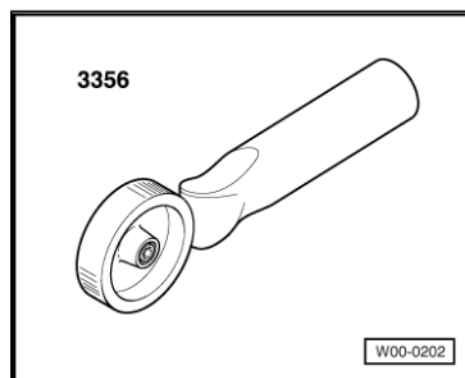
- Paint the handle ➔ Paint manual - Repairing paintwork in plastic parts .
- Installation is performed in the reverse sequence to the removal.



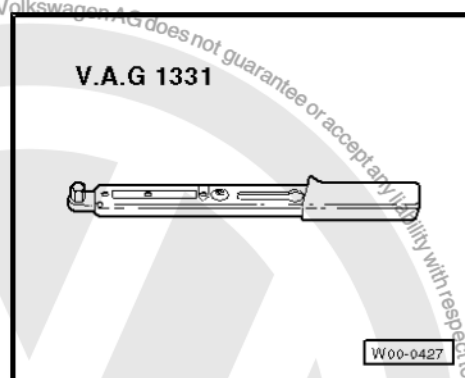
1.12 Rear door lock - remove and install

Special tools and workshop equipment required

- ◆ Pressure roll - 3356-

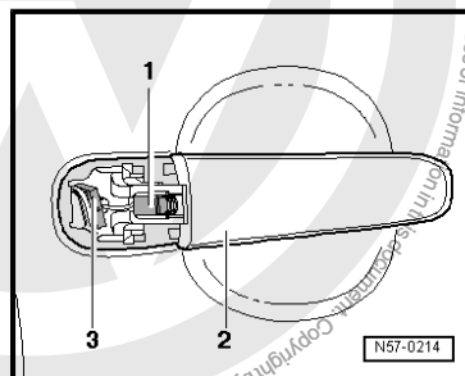


- ◆ Torque wrench - 5 to 50 Nm (1/2" drive) - VAG 1331-



Removal:

- Remove the lock cylinder housing ⇒ [page 79](#) .
- Disengage the clip -1- from the door handle -2-.





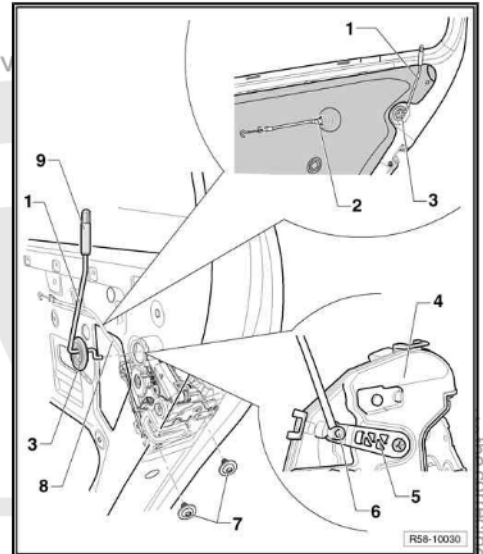
- With the door window closed, remove the rear door lining ⇒
General body repairs, interior; Rep. gr. 70 ; Lining / insulation



Note

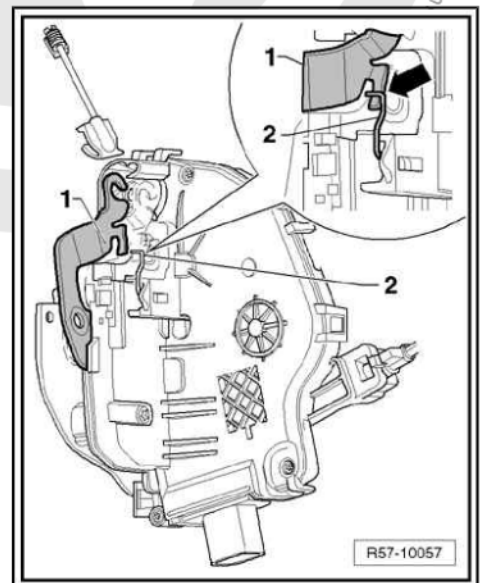
In 2013 ➤ models, the versions with electric locking do not have this rod -1- and the eyelet -3-.

- Disengage eyelet -3- from internal door panel and disengage rod -2- from bushing -64- in lever -5-
- Detach adhesive tapes -2- that fasten sealing membrane on the lock operating cable -8-.
- Partially remove the door sealing membrane to access the lock.
- Disengage the connector from the left/right rear central locking system motor - V307/V308- in the lock.
- Remove the securing bolts -7- (Torque: 20 Nm) from the door lock -4- and remove the lock through the installation opening.



Installation:

- Place spring -2- under the lock operating lever -1-, with thin nose pliers.
- Installation is performed in the reverse sequence to the removal.





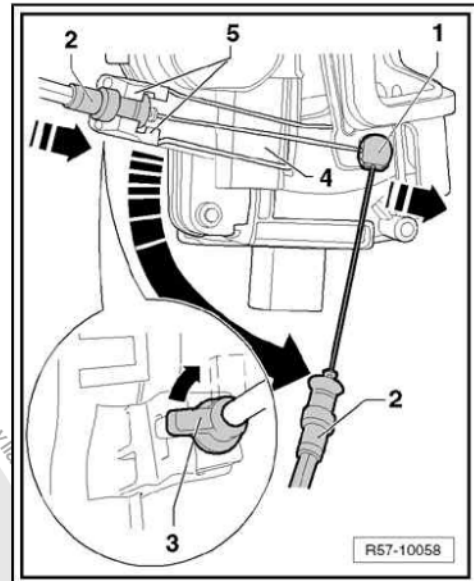
1.13 Lock Bowden cable - replace

Removal:

- Remove the door lock ➔ [page 82](#) .
- Turn lock -3- on the cable cover by 90°.
- Disengage the cable from locks -5- and move the cable -2- by 90° to align the cable fastener -1- with the grooves on the lock lever and remove it.
- Disengage the cable and remove it.

Installation:

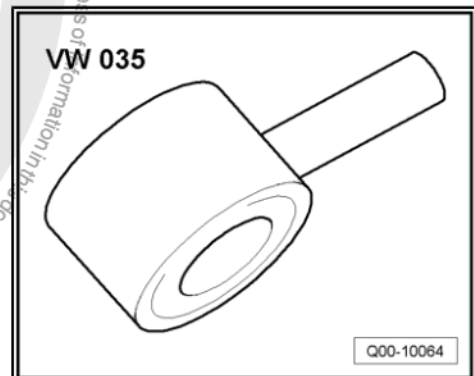
- Installation is performed in the reverse sequence to the removal.



1.14 Lock button (locking rod) - remove and install

Special tools and workshop equipment required

- ◆ Puller and fitter - VW 035-





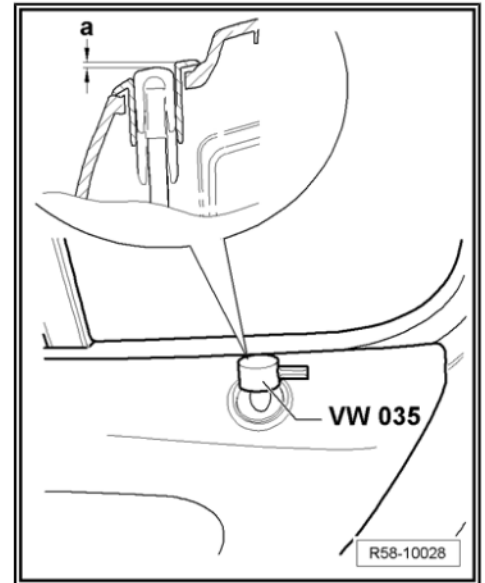
Removal:

- With the lock button totally raised, fit Puller and Fitter - VW 035- and loosen the pin.
- Remove the tool with the button.

Installation:

- Insert button in the Puller and fitter - VW 035- and screw the button in order that, when in locked position, it is at a distance -a- from the door lining.

Dimension -a- = 0 to - 1 mm



1.15 Door sealing membrane - remove and install

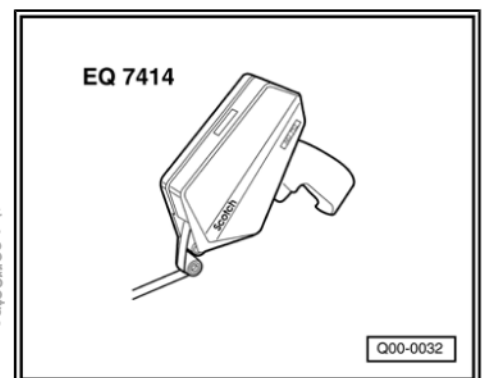


WARNING

- ◆ *When handling chemicals follow the safety instructions ⇒ Chemical Products Manual: Rep. gr. 00*
- ◆ *Assignment of Chemical Materials ⇒ Electronic Parts Catalogue "ETKA"*

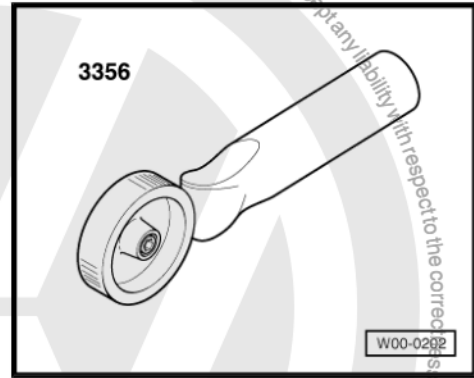
Special tools and workshop equipment required

- ◆ Transferable adhesive tape applicator - EQ 7414-





◆ Pressure roll - 3356-

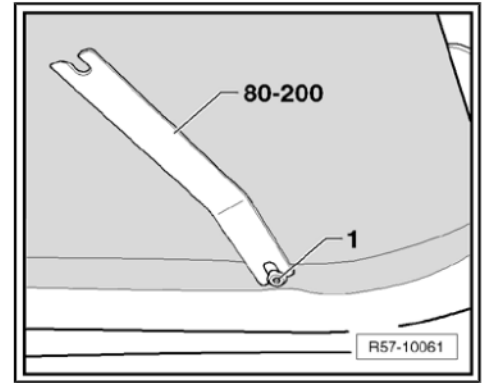


Removal:

- Remove the door lining ⇒ General body repairs, interior; Rep. gr. 70 ; Lining / insulation - Door linings - remove and install .



- Remove the adhesive tapes that fasten the membrane to the lock operating cable and wiring harnesses.
- Remove bushings -1- with the removal lever - 80-200- .
- Remove and install ⇒ Communication; Rep. gr. 91 ; Radio, telephone, navigation system .
- Detach the sealing membrane and remove it.
- Remove any remaining adhesive from the internal door panel using the cleaning solution - D 009 401 04- .



Note

Moisten a cloth with the cleaning solution - D 009 401 04- and gently apply it over the affected area. Allow the product to work for a moment and then rub towards the centre starting from the edges. Repeat the operation if necessary. Next, rub the surface with a cloth until it is completely dry.

Installation:

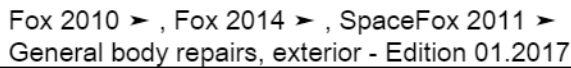
Installation is performed in reverse to the removal sequence, observing the following:



Note

- ◆ *0,2 ± 0,02 mm thick Polypropylene film. Adhesive strength ≥ 4 N/cm.*
- ◆ *The membrane may be reinstalled if there is no damage such as stretching or wrinkles which can fatally compromise the seal against water and dust.*
- ◆ *The membrane has an sensitive acrylate-based adhesive coating that ensures it can be removed up to 3 times without affecting the adhesive performance. If the adhesive coating is damaged, that is, removed by the fourth time, install the membrane by using transferable adhesive tape ⇒ Chemicals Manual as indicated below.*
- ◆ *Apply transferable adhesive tape Chemicals Manual to the internal door panel (membrane adhesion area) with the transferable adhesive tape roller - EQ 7414- , should the membrane have lost its adhesive property.*
- Install the membrane by passing the cable and harnesses through the holes and paste it to the internal door panel.
- Press the door sealing membrane with the pressure roll - 3356- .
- Fasten the sealing membrane to the lock operating cable and wiring harnesses.
- Install the door lining ⇒ General body repairs, interior; Rep. gr. 70 ; Lining / insulation - Door linings - remove and install .

1.16 Door sealing packings - assembly overview



-
- Diagram illustrating the installation of a rear window blind. The diagram shows the car's interior with the rear window open. Callouts indicate the following components:
- 1: A screw for the blind track.
 - 2: The blind track.
 - 3: A bracket for the blind.
 - 4: A bracket for the blind.
 - 5: A bracket for the blind.
 - 6: A bracket for the blind.
 - 7: A bracket for the blind.
- R58-0015

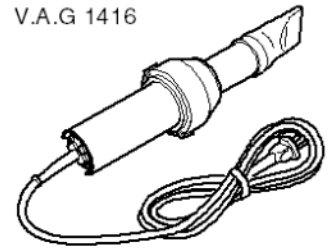
- ◆ When handling chemicals follow the safety instructions ⇒ Chemical Products Manual; Rep. gr. 00
- ◆ Assignment of Chemical Materials ⇒ Electronic Parts Catalogue "ETKA"

88 Rep. gr.58 - Rear doors, door components



◆ Hot air blower - VAG 1416-

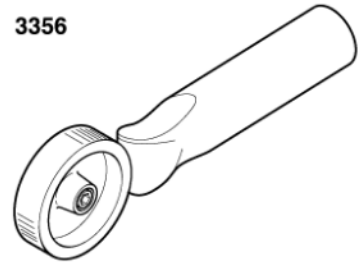
V.A.G 1416



W00-0004

◆ Pressure roll - 3356-

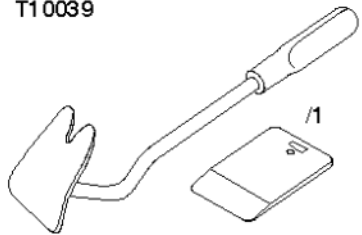
3356



W00-0202

◆ Wedge - T 10039/1-

T1 0039



W00-0973



Removal:

- Remove securing pins -1-.



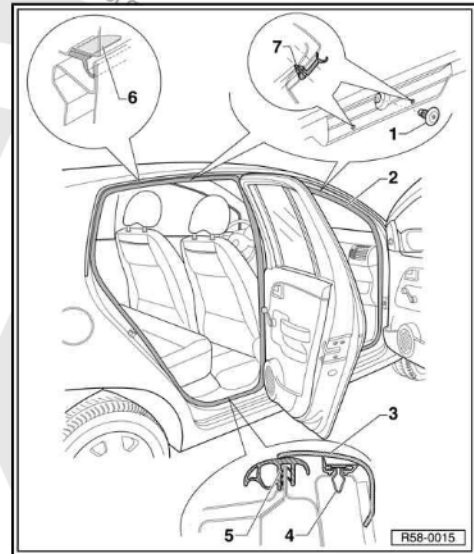
Note

For vehicles produced as of chassis C4103617, the rubber tab fastened by fastening pin -1- no longer exists.

- Heat up trim with the hot air blower - VAG 1416- .
- Detach trim using wedge - T 10039/1- .

Installation:

- Clean door frame in the adhesion area with adhesive remover - D 002 000 A2- , then apply cleaning solution - D 009 401 04- . Dry the section with a dry cloth.
- Heat up the trim adhesive tape and door frame in the assembly section with the hot air blower - VAG 1416- at a temperature of 30 - 40 °C.
- Press packing -7- fitting (above front door and above rear door) against holes in the door frame.
- Remove double-sided tape liner -6-, and glue the trim and centralize it in the C-pillar area. Firmly press packing (above 10 N) with a pressure roll - 3356- . Only move the pressure roll in one direction.



Note

Do not move it back and forth.

- Install pins -1-.



Note

- ◆ *For vehicles produced as of chassis C4103637, the rubber tab fastened by fastening pin -1- no longer exists.*
- ◆ *After assemble, the door must be kept open for a minimum period of 30 minutes so that the door's pressure on packing do not lead to premature packing detaching.*

1.18 Internal door trim - remove and install

Removal:

- Remove front door threshold trim ⇒ General body repairs, interior; Rep. gr. 68 ; Internal Equipment .
- Disengage and remove the trim.

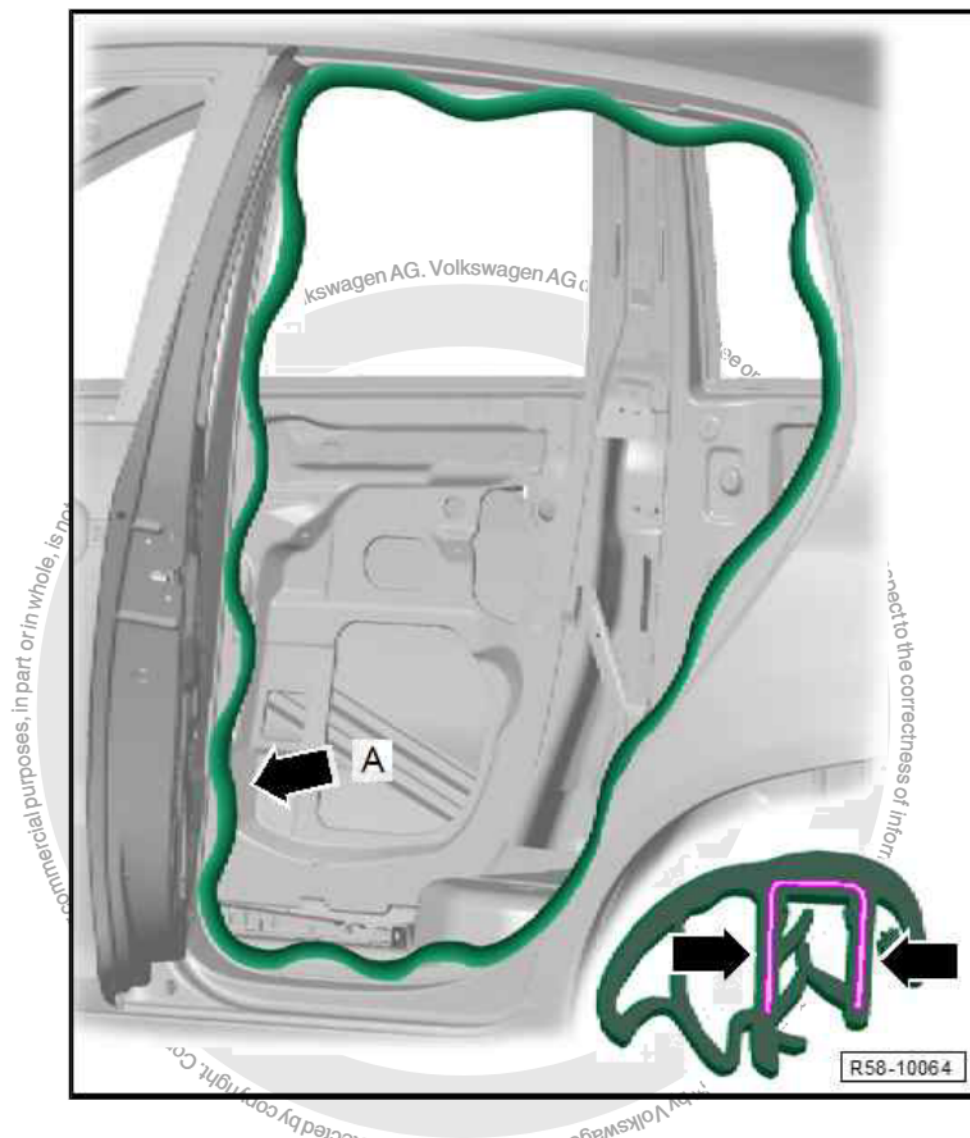


Installation:



Note

- ◆ *The vulcanized splice of the packing shall be mounted at the same height of the lock operating lever in the bonnet -arrow A-.*
- ◆ *For partially removed trim, it is necessary to press the trim sides -arrow- before assembly.*



- Manually engage the trim, initially in the door crest, and engage the remaining trim spots distributing trim tension.
- Slightly press the trim with a rubber hammer.
- Install front door threshold trim ⇒ General body repairs, interior; Rep. gr. 68 ; Internal Equipment .



60 – Sunroof

1 Sliding / tilting sunroof (Fox)

1.1 Operation

The sliding / tilting sunroof is opened and closed by the sliding sunroof adjustment regulator - E139- , with the ignition switched on.

It is possible to open or close the sliding / tilting sunroof with ignition off if driver's or passenger's door is not open.

There are marks on the sunroof sliding adjuster which correspond to the established opening positions - Glass lid opening positions. However, it is possible to open the roof in any desired intermediary position on the sliding rail or tilt, by turning the control to the corresponding direction.

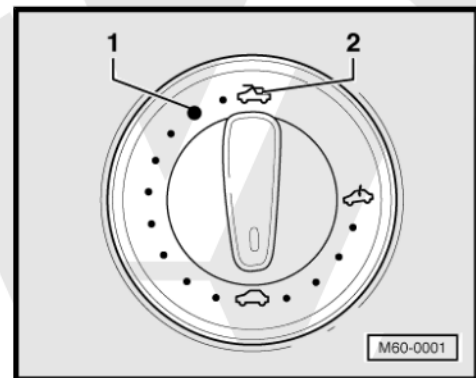
The Sliding/tilting sunroof opening with the control in position -1-, the so-called comfort position, significantly reduces the wind noises experienced with total opening in control position -2-.

Sliding/tilting sunroof is equipped with closing strength limiter in the sliding region. If there is any obstacle during closing operation, roof will automatically reopen.

Additionally, there is an emergency closing feature. Upon problems with closing, sliding roof may be firmly closed by pressing the command, which shall be in the "closed sunroof" position.

Closing strength limiting feature is off upon emergency closing feature.

The Sliding sunroof motor - V1- is protected from excessive heating by an operation length limitation. The protective mechanism kicks in after an uninterrupted activation of around two minutes. It may only be activated again after a cooling period.



1.2 Sliding/tilting sunroof with glass lid - assembly overview



WARNING

- ◆ When handling chemicals follow the safety instructions ⇒ Chemical Products Manual; Rep. gr. 00
- ◆ Assignment of Chemical Materials ⇒ Electronic Parts Catalogue "ETKA"



1 - Glass lid for sliding/tilting sunroof (safety toughened glass)

- ☐ Remove glass lid for sliding / tilting sunroof ➔ [page 94](#) .
- ☐ Install glass lid for sliding/tilting sunroof ➔ [page 94](#) .
- ☐ Adjust glass lid for sliding/tilting sunroof ➔ [page 95](#) .

2 - Cover trim

- ☐ Packing joint centralized in rear region.
- ☐ Roof packing replacement ➔ [page 96](#)

3 - Sunroof lining

- ☐ Remove and install sun protector ➔ [page 97](#) .

4 - Sliding

5 - Folding frame

6 - Water chute

- ☐ Remove: remove guide with steel cable

7 - Bolt

8 - Tip

- ☐ Use adhesive Butyl cord for sealing -AKL 450 005 05-

9 - Guide frame

- ☐ Lubricate guide channels with special grease if necessary -G 000 450 02- , otherwise, operation is not ensured.

10 - Sliding sunroof motor - V1-

- ☐ Remove and install ➔ [page 99](#)
- ☐ Adjust activation (zero position) ➔ [page 100](#)

11 - Bolt

- ☐ Torque: 3.5 Nm
- ☐ Must always be replaced

12 - Sliding sunroof adjustment control unit - J245-

- ☐ Remove and install ➔ [page 98](#)
- ☐ Selector command is in the command unit.
- ☐ Remove selector key ➔ [page 99](#)

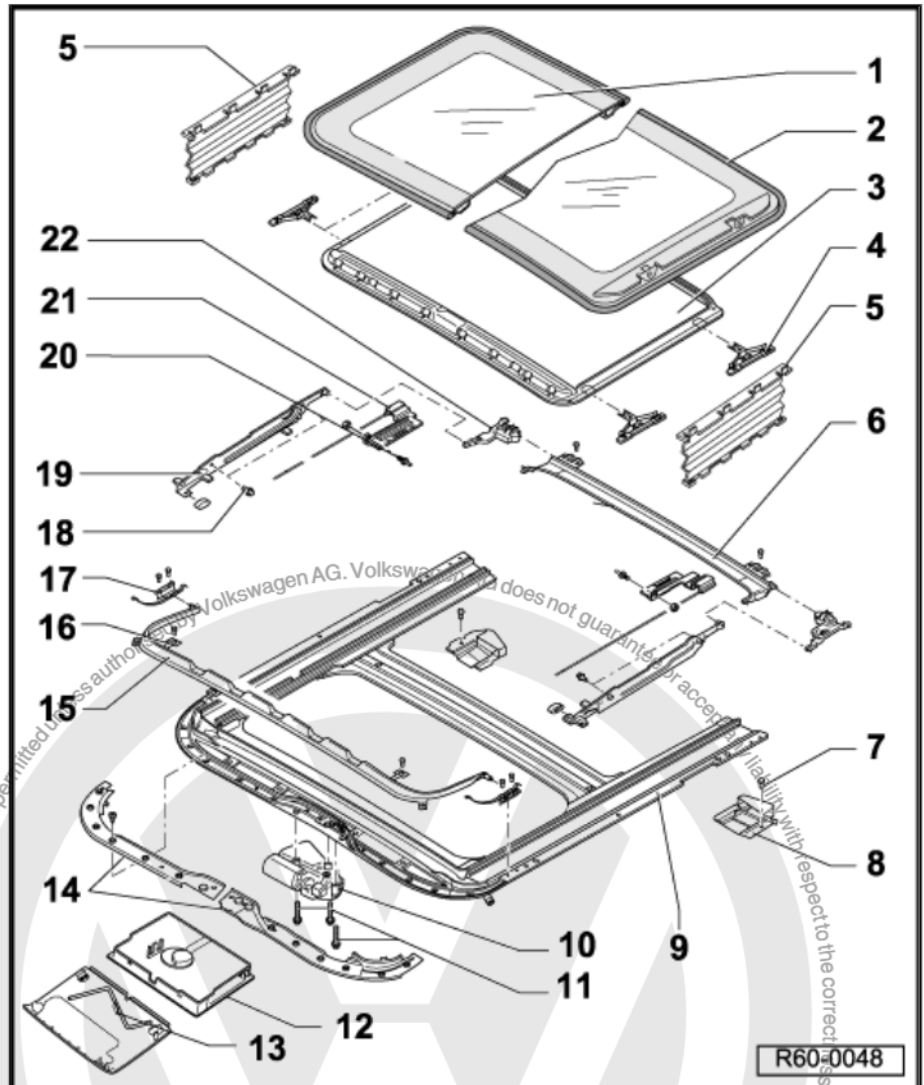
13 - Hexagonal wrench for manual operation

- ☐ Fitted to the electric mechanism lid.

14 - Cable cap

15 - Air deflector

- ☐ Remove and install ➔ [page 97](#)

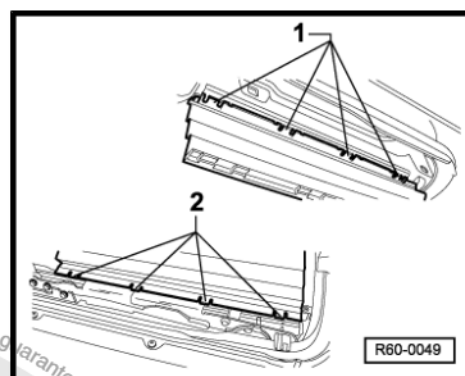




- 16 - Hinge
- 17 - Deflector activation spring
- 18 - 25-pin connector -T25-
 - ❑ Torque: 4.5 Nm
- 19 - Sliding guide
 - ❑ Remove and install ➔ [page 102](#)
- 20 - Sliding pin
- 21 - Guide with steel cable
 - ❑ Remove and install ➔ [page 102](#)
- 22 - Chute positioner

1.3 Sliding/tilting sunroof glass lid - remove

- Push sunroof lining backwards
- Tilt sunroof lid.
- Disengage locks -1- from folding frame of the glass lid metal structure and disengage locks -2- from sunroof guide frame.

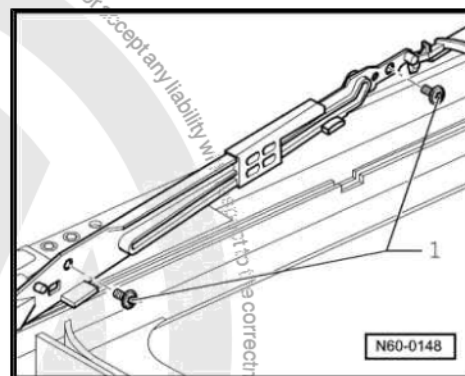


- Remove the fastening bolts -1- (Torx -T25- ; Torque: 4.5 Nm).
- Remove sliding/tilting sunroof lid from above.



Note

The sliding/tilting sunroof must not be put in "open" position when glass lid is removed, as the water chute would not be compressed by the glass lid and might stick to the roof.



1.4 Glass lid for sliding/tilting sunroof - install



Note

Lid must be installed in position "0"

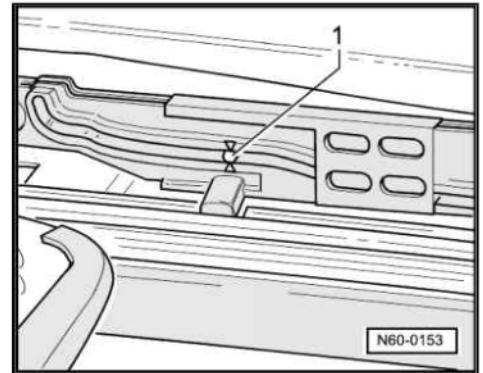


Position "0"

- Guide sliding pin -1- must be aligned with the marks in guide sliding device.

Otherwise, adjust to ensure due alignment.

- Place the sliding/tilting sunroof lid on top and screw fastening screws (sliding device/lid) on guide sliding device.

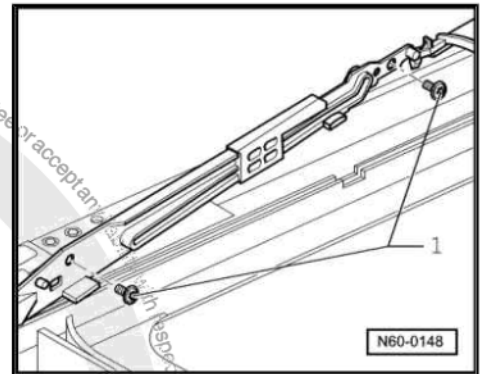


- Moderately tighten fastening screws -1- (Torx -T25-).

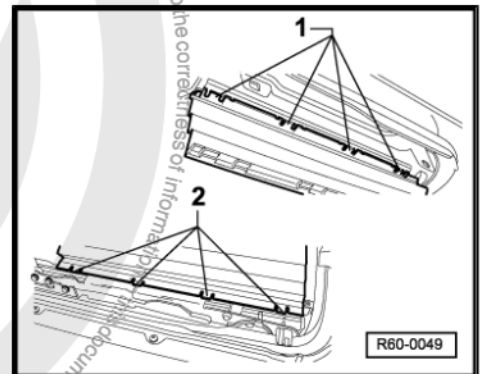


Note

Tighten the fastening bolts after the lid height adjustment ⇒ page 95 Torque: 4.5 Nm).



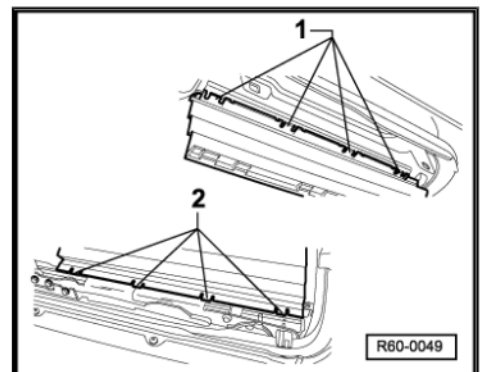
- Fit locks -1- to folding frame of the glass lid metal structure, and disengage locks -2- from the sunroof guide frame.
- Turn the sunroof lid into closed position.
- Push sunroof lining forward.



1.5 Glass lid for sliding/tilting sunroof (height adjustment) - adjust

Sliding/tilting sunroof zero position in order

- Push sunroof lining backwards.
- Tilt sunroof lid.
- Disengage locks -1- from folding frame of the glass lid metal structure and disengage locks -2- from sunroof guide frame.





- Loosen the fastening screws -1- (Torx -T25- ; Torque: 4.5 Nm).
- Move glass lid into "open" position.
- Move glass lid into "closed" position.
- Adjust glass lid height in the front and rear for both sides, as follows:

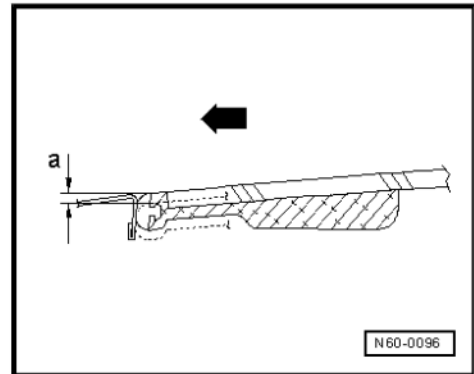
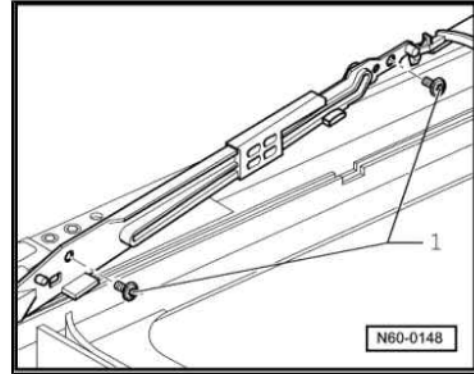
Lid adjustment in front section:

a = 0 to 1 mm below roof level.

Arrow = indicating vehicle front.

Lid adjustment, rear section:

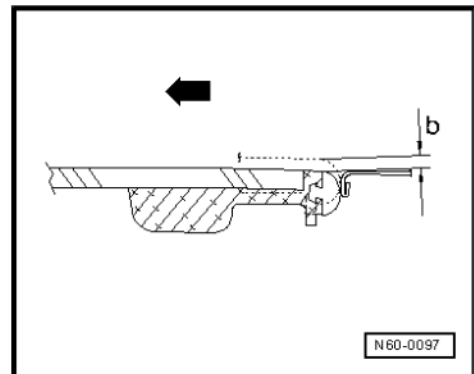
b = 0 to 1 mm above roof level.



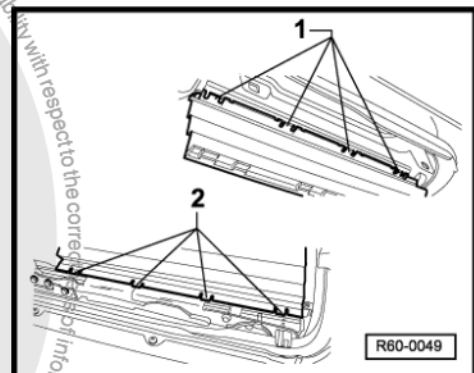
Arrow = indicating vehicle front.

- Tighten the glass lid screws (Torque: 4.5 Nm).

Always symmetrically adjust right and left sides of the glass lid.



- Fit locks -1- to folding frame of the glass lid metal structure, and disengage locks -2- from the sunroof guide frame.
- Turn the sunroof lid into closed position.
- Push sunroof lining forward.

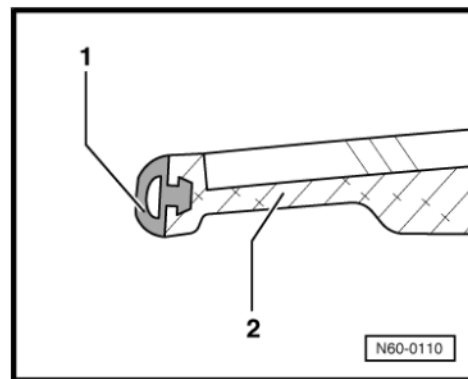


1.6 Lid trim - replace

- Remove the sliding/tilting sunroof glass panel.
- Disengage packing -1-.



- Press new packing onto lid metal structure -2-.



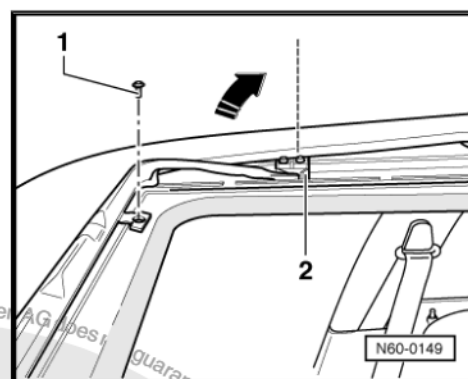
1.7 Air deflector - remove and install

Removal:

- Open sliding/tilting sunroof completely
- Remove the bolt -1-.
- Move deflector vertically towards the -arrow- and disengage it from rail -2-.

Installation:

Installation is performed in the reverse sequence to the removal.



1.8 Sunroof lining - remove and install



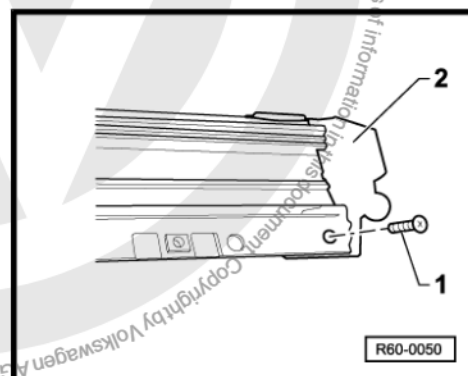
WARNING

- ◆ When handling chemicals follow the safety instructions ⇒ Chemical Products Manual; Rep. gr. 00
- ◆ Assignment of Chemical Materials ⇒ Electronic Parts Catalogue "ETKA"

Removal:

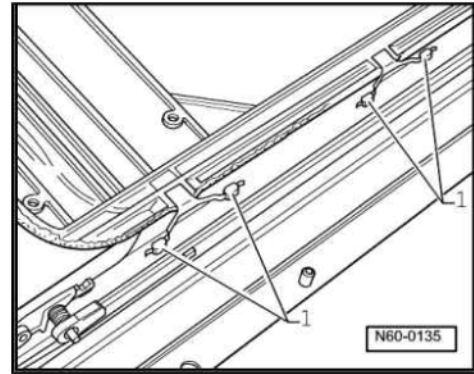
- Remove sunroof
- Remove screw -1- and disengage tip -2-.
- Pull roof lining backwards and disengage from frame.

Installation:





- Put roof lining, fitting roof lining slider -1- (sliders are fastened to roof lining) to frame guides.

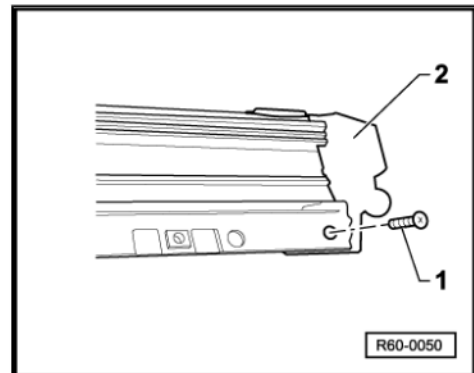


- Install screw -1- and fit tip -2-.



Note

Seal tip -2- with Butyl adhesive cord - AKL 450 005 05- .



1.9 Sliding sunroof movement control unit - J245- - remove and install

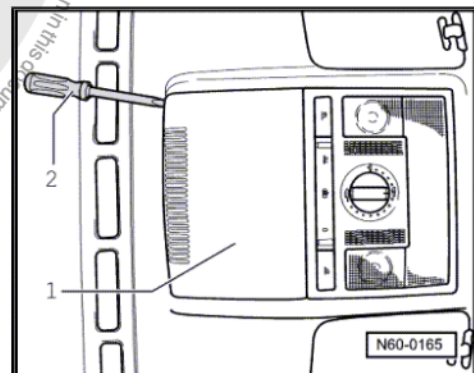


Note

- ♦ Pay attention to the coding instructions in the radio user manual before disconnecting the battery.
- ♦ After disconnecting the battery, see that the vehicles' accessories (radio, clock, power window) are checked according to the repair manual and/or operation instructions after disconnecting the battery.

Removal:

- Disconnect the battery ground strap.
- Detach the cover -1- of the driver unit with a screwdriver -2-.
- Disconnect Ultra-sound sensor for alarm system - G209- connectors if any.

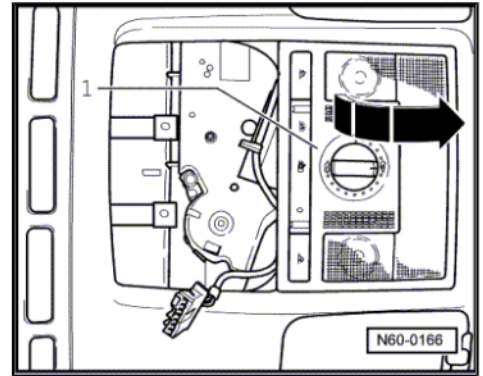




- Disconnect the Sliding sunroof adjustment control unit - J245-1- (with selector key and internal light) and remove from shaped roof from below and front -arrow-.
- Remove fitting connections.

Installation:

Installation is performed in the reverse sequence to the removal.



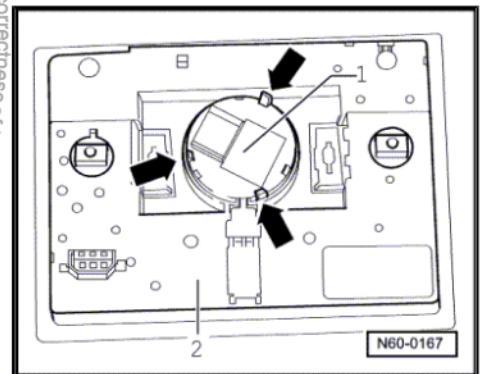
1.10 Sliding/tilting sunroof selector key - remove and install

Removal:

- Remove the Sliding sunroof adjustment control unit - J245- .
- Unlock locking tabs -arrows- on the rear of the control unit and remove selector key -1- from command unit -2-.

Installation:

Installation is performed in the reverse sequence to the removal.



1.11 Sliding sunroof activation motor -V1- - remove and install



Note

Only remove and install sliding/tilting sunroof activation motor with roof closed (zero position)

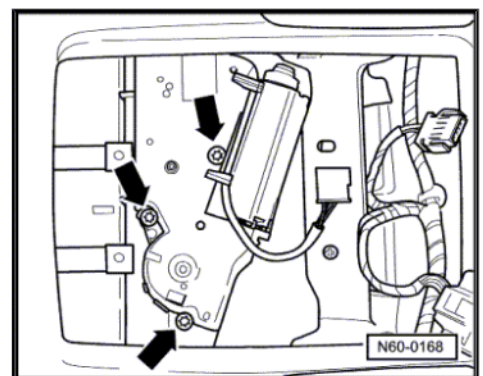
Removal:

- Remove the Sliding sunroof adjustment control unit - J245- ⇒ [page 98](#) .
- Remove screws -arrows- and remove sliding/tilting roof activation.
- Disconnect connections and cables

The driver motor bolts are micro-armoured and must always be replaced (Torque: 3.5 Nm)

Installation:

Installation is performed in the reverse sequence to the removal.





1.12 Sliding sunroof motor - V1- (zero position) - adjust

Adjustment of position zero may be necessary when activation engine is replaced; not removed in position zero; or when sliding/tilting roof is closed or opened by manual operation.

After removing the activation engine, connect the engine connectors and follow the steps below

- With selector key, select "Fully opened roof".
- With selector key, select "Fully closed roof".
- With selector key, select "Fully opened tilting roof".
- With selector key, select "Fully closed tilting roof".

After executing the sequence above, install the roof activation engine in the closed position (zero position).

1.13 Sliding sunroof activation motor - V1- - program

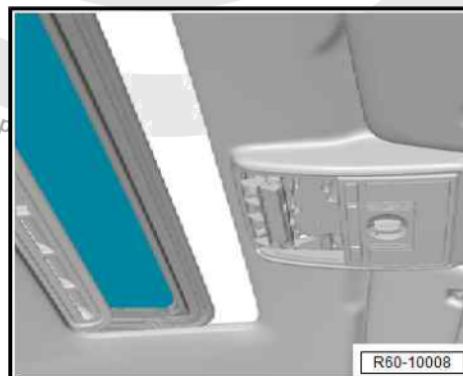


Note

Programming may be eventually lost when disconnecting the vehicle battery's earth wire or when the activation motor is replaced.

Program:

- Position the sliding/tilting sunroof ajar and move the selector key to "closed" position.





- After connecting all connectors, press the selector key in “closed” position -Arrow- for 35 seconds.



Note

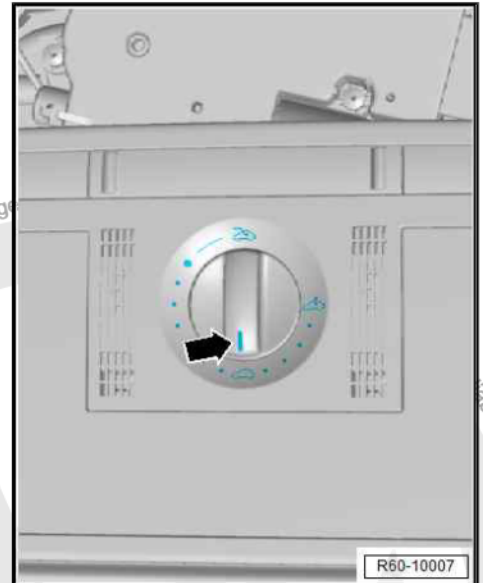
During this period, the sliding/tilting sunroof may move and stop random positions.

- After the 35-second period, release the selector key and press it again, within a period of 6 seconds, until the Sliding sunroof activation motor - V1- completes the programming cycle and comes to a complete stop.
- After completing the programming process, carry out tests by opening and closing the sliding/tilting sunroof in all positions.



Note

If the unit fails to reach any position during operating tests, disconnect the Sliding sunroof activation motor - V1- connectors, wait 10 seconds, reconnect the connectors and repeat the programming process.



1.14 Parallelism - check

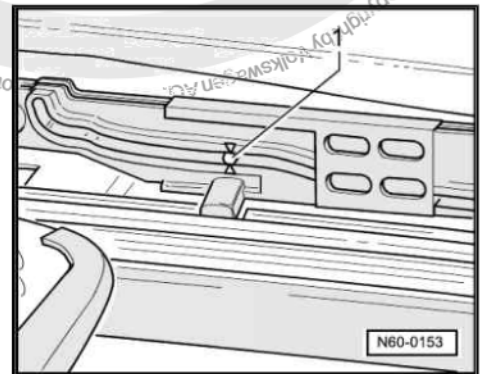
- Remove folding frames from sliding/tilting roof.



Note

The glass lid must be in zero position (lid closed)

Sliding pin -1- must be aligned with marks in sliding device guide.



1.15 Parallelism - adjust



Note

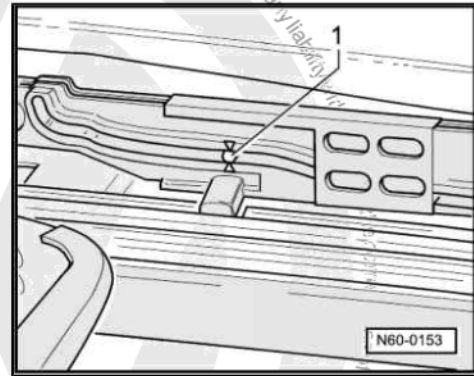
Parallelism adjustment can only be carried out with electric activation engine and glass lid removed (in zero position).

- Remove sliding/tilting roof activation motor.



Zero position:

- Place sliding pin -1- aligned with marks in sliding device guide.
- Install roof activation motor (zero position) to this position.



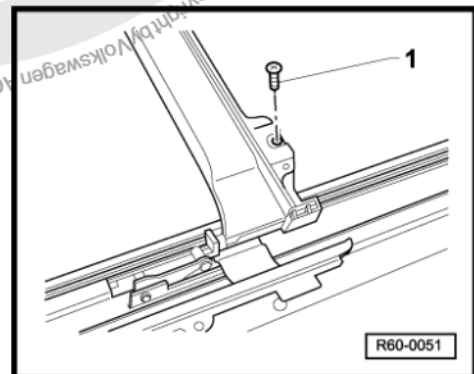
1.16 Sliding guide - remove and install

Removal:

- Remove sliding/tilting sunroof glass lid.
- Remove sunroof ⇒ [page 102](#)
- Remove the air deflector.
- Remove fastening -1-screw from chute in positioner.
- Disengage sliding device guide from guide frame.

Installation:

Installation is performed in the reverse sequence to the removal.



1.17 Sunroof - remove and install

Removal:

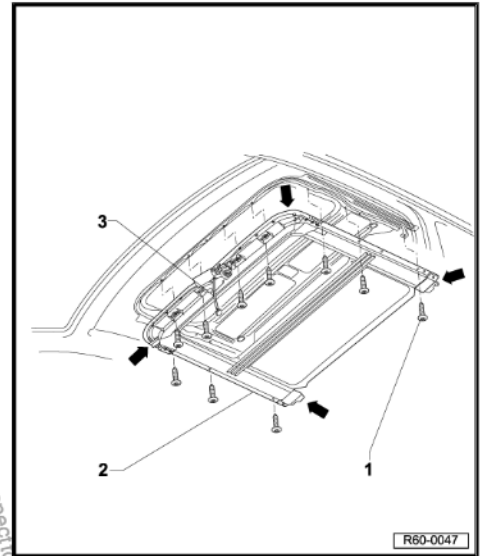
- Remove glass panel from sliding/tilting roof for better assembly access.
- Remove roof lining ⇒ General body repairs, interior; Rep. gr. 70 ; Linings / insulations
- Disconnect harness from Sliding sunroof motor - V1- -3-.
- Disengage water drain hoses from guide frame-1- -arrows-.



- Remove screws -2- and guide frame from the vehicle, with the assistance of another mechanic.

Installation:

- Support assembly unit -1- on rear housings and turn upwards (fastening pins must be inserted in assembly holes).
- Place bolts -2-.
- Check positioning of roof cables and electrical consumers, and establish connection if necessary.
- Fasten the carrier unit -1- of the sliding/tilting sunroof driver -3-, from the left and right sides backwards (Torque: 8 Nm).
- Install sliding sunroof activation motor connection -3-.
- Install water drain flexible tubes -arrows-.
- Install shaped roof ⇒ General body repairs, interior; Rep. gr. 70 ; Linings / insulations .
- Install sliding/tilting sunroof glass lid.



1.18 Guide with steel cable - remove and install



WARNING

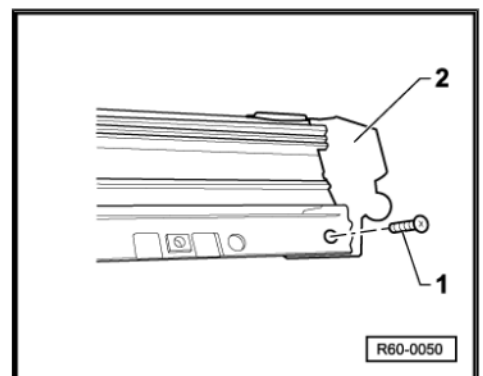
- ◆ When handling chemicals follow the safety instructions ⇒ Chemical Products Manual; Rep. gr. 00
- ◆ Assignment of Chemical Materials ⇒ Electronic Parts Catalogue "ETKA"

- Remove sliding/tilting sunroof glass lid.
- Remove sunroof.
- Remove Sliding sunroof motor - V1- .
- Remove sliding device guides.
- Remove screw -1- and disengage tip -2-.
- Pull guide with steel cable outwards.



Note

Seal tip -1- with Butyl adhesive cord - AKL 450 005 05- in the opposite side from guide rail when installing.



1.18.1 Assembly notes:

- ◆ Always replace guides with steel cable in pairs.
- ◆ Lubricate guide channels with special grease - G 000 450 02- .
- ◆ Install sunroof.
- ◆ Adjust parallelism.
- ◆ Install glass lid for sliding/tilting sunroof.



1.19 Drain hoses - clean

1.19.1 Front water drain hoses:

Front water drain hoses ⇒ [Item 2 \(page 104\)](#) pass throughout pillars A and end on water case. Clean as from the sliding/tilting roof cutout.

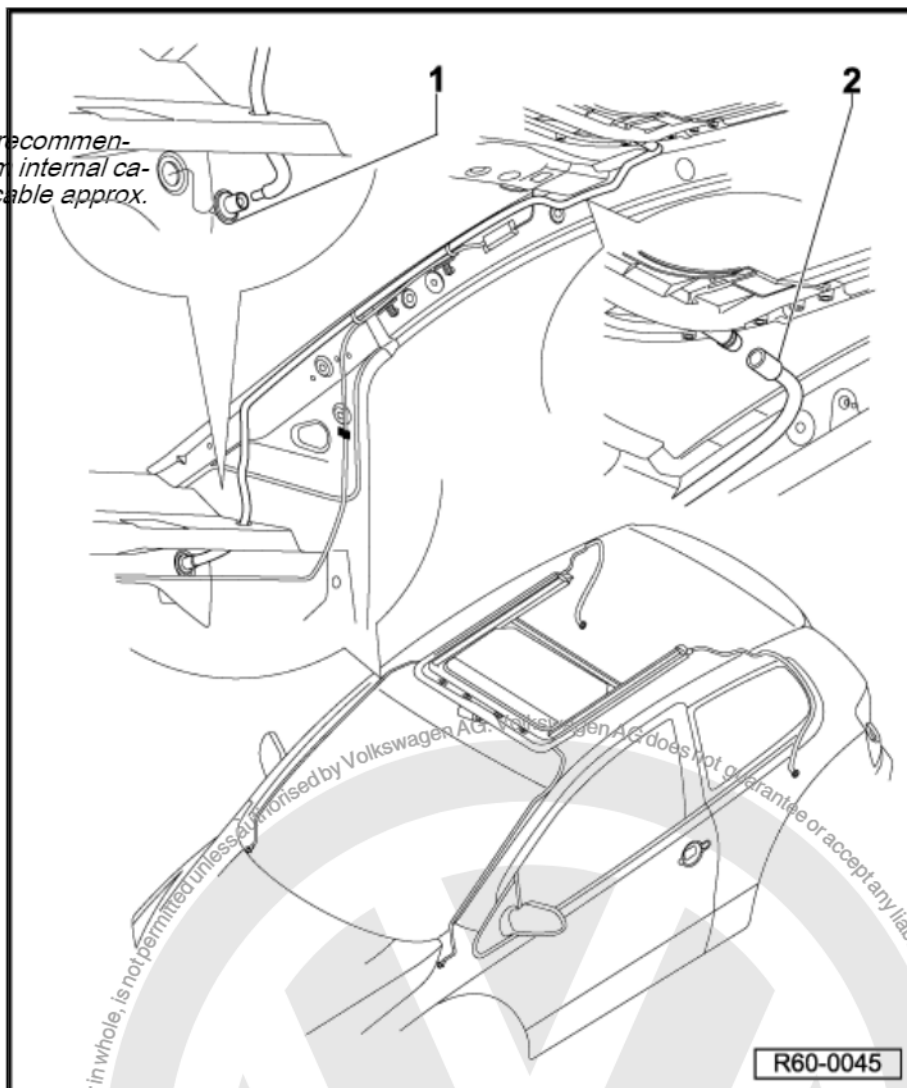
1 - Water drain valve



Note

A properly-built tool is recommended for cleaning as from internal cable of a speedometer cable approx. 2300 mm long.

2 - Water drain hose



1.19.2 Rear water drain hoses:

Rear water drain hoses ⇒ [Item 1 \(page 105\)](#) pass through and end on the roof rear edge before rear lid. Clean as from hose rear edge. Remove cover to perform this.



1 - Water drain hose

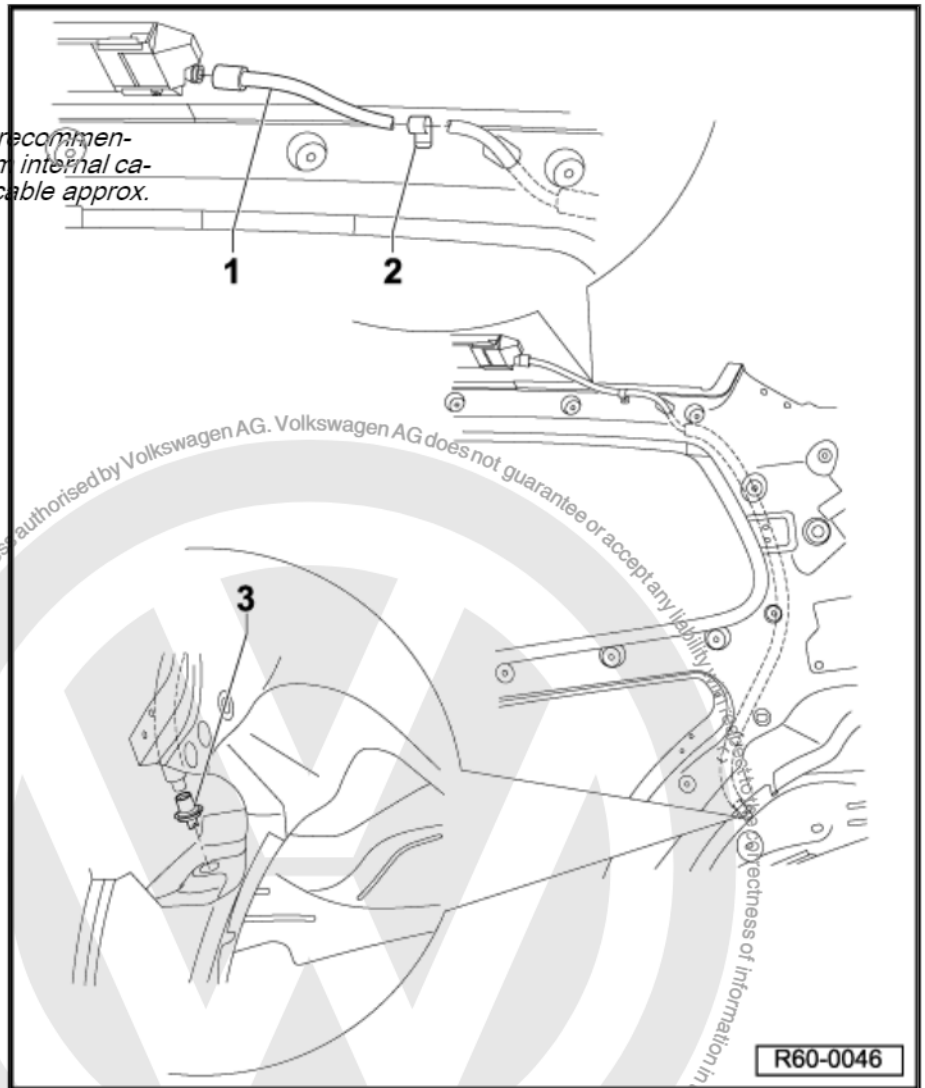


Note

A properly-built tool is recommended for cleaning as from internal cable of a speedometer cable approx. 2300 mm long.

2 - Clip

3 - Water drain valve



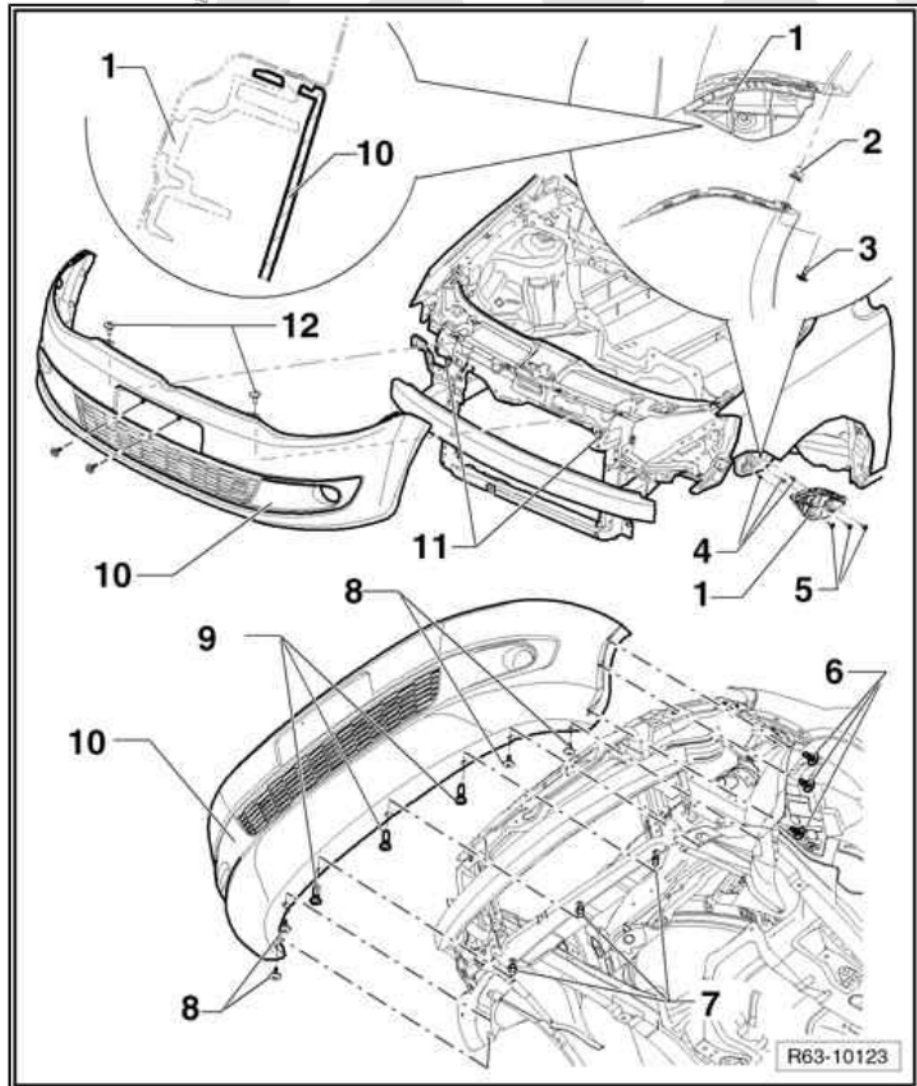


63 – Bumpers

1 Front bumper

1.1 Front protector - assembly overview

- 1 - Side guide
- 2 - Plastic bushing
 - ☐ Replace, as required
- 3 - Bolt
 - ☐ 2 units
 - ☐ Torque: 1.5 Nm
- 4 - Pop rivet nut
 - ☐ To install, use the POP NUT rivet nut applicator - VAG 1765B- or POP NUT rivet nut applicator - EQ 7422- .
- 5 - Bolt
 - ☐ 6 units
 - ☐ Torque: 3 Nm
- 6 - Bolt
 - ☐ 6 units
 - ☐ Torque: 1.5 Nm
- 7 - Pop rivet nut
 - ☐ To install, use the POP NUT rivet nut applicator - VAG 1765B- or POP NUT rivet nut applicator - EQ 7422- .
- 8 - Bolt
 - ☐ 4 units
 - ☐ Torque: 1.5 Nm
- 9 - Bolt
 - ☐ 3 units
 - ☐ Torque: 3 Nm
- 10 - Front protector
- 11 - Pop rivet nut
 - ☐ To install, use the Pop rivet nut applier - VAG 1765B- or Pop rivet nut applier - EQ 7422-
- 12 - Bolt
 - ☐ 2 units
 - ☐ Torque: 3 Nm

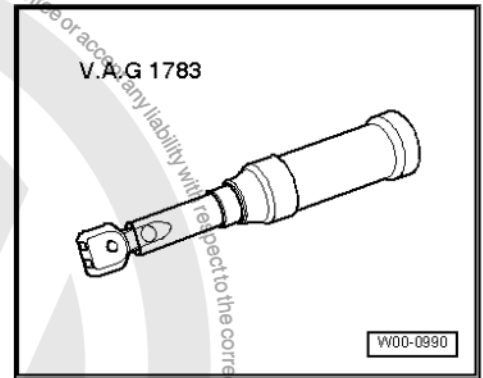


1.2 Front bumper protector - remove and install

Special tools and workshop equipment required

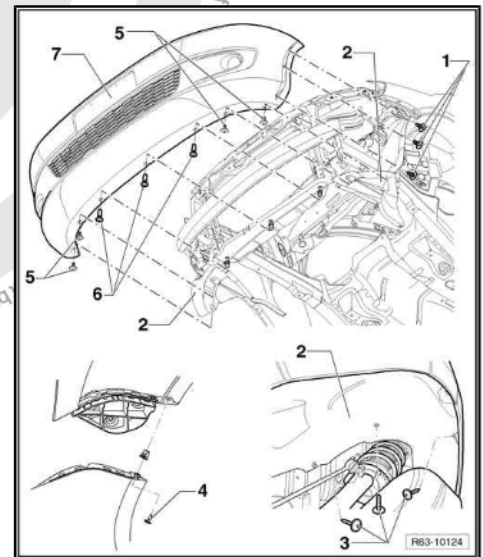


- ◆ Torque wrench 2 to 10 Nm - VAG 1783-



Removal:

- Remove the front grid.
- Remove the bolts -1- and -3- (Torque: 1.5 Nm) from the wheel housing protectors.
- Move wheel house protector downwards and remove the screws -4- (Torque: 1.5 Nm).
- Remove the screws -5- (Torque: 1.5 Nm).

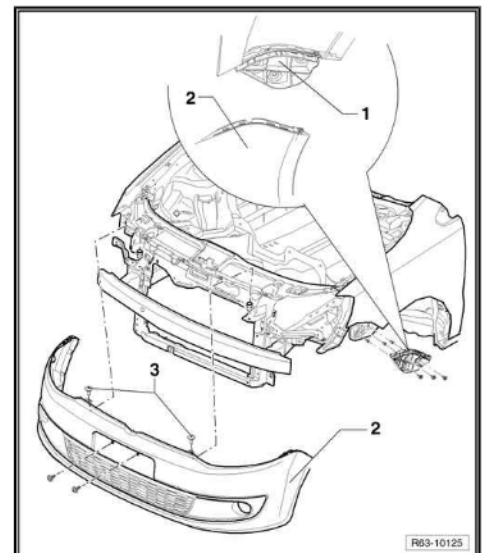


- Remove the screws -6- (Torque: 3 Nm).
- Disengage front protector -2- from guide -1-.
- Remove fastening screws -3- from front panel protector.
- Remove the front protector.
- Carefully remove front protector -3- forward.
- Disconnect connectors from fog lights and external temperature sensor - G17- .

Installation:

Install is performed in the reverse sequence, observing the following:

- Check clearance dimensions ⇒ Body Repairs; Rep. gr. 00 ; Technical data - Body clearance dimensions before tighten fastening screws.



1.3 Front protector support - assembly overview



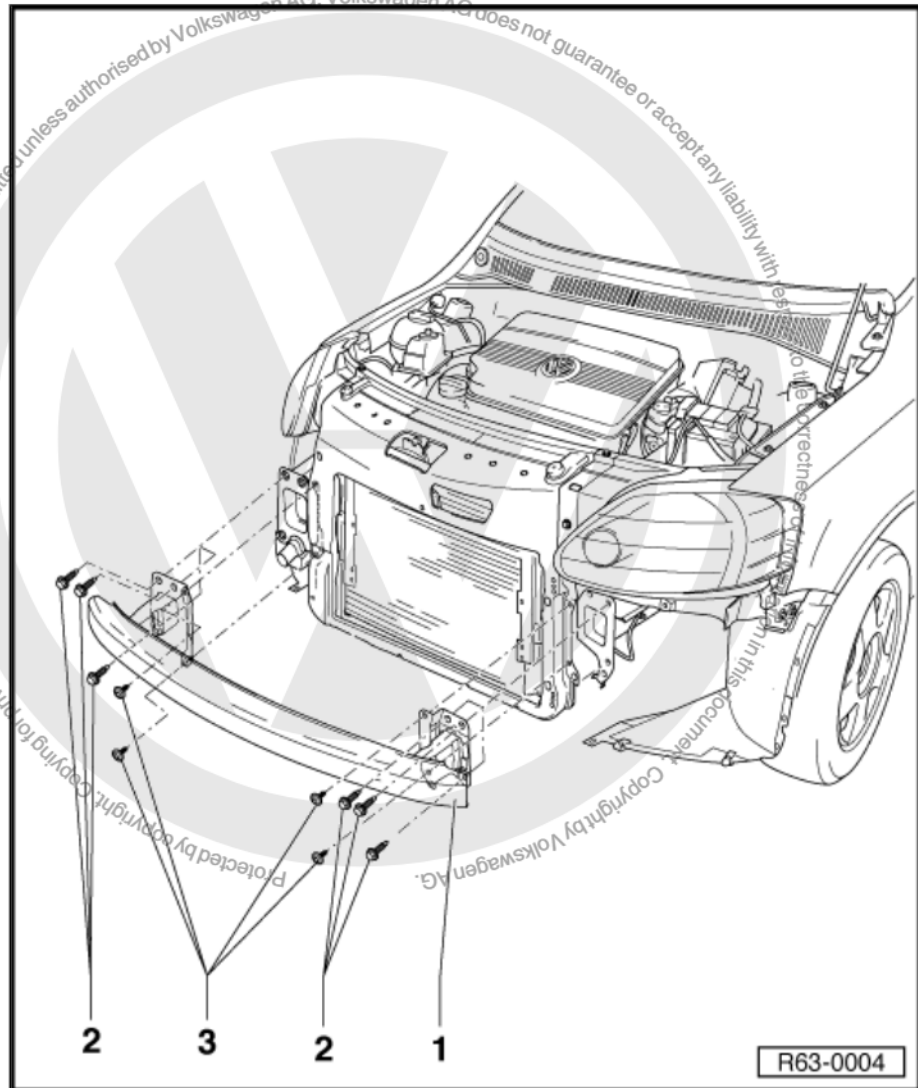
1 - Front protector support

2 - Bolt

- 6 units
- Torque: 35 Nm

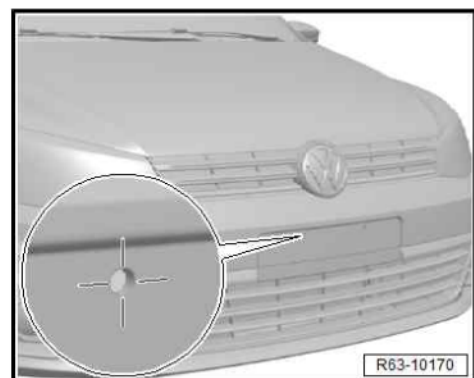
3 - Bolt

- 4 units
- Torque: 8 Nm



1.4 Fastening of the front license number holder - install

- Drill with a 6-mm drill bit in the points marked in the front protection. Protect adjacent areas with masking tape.



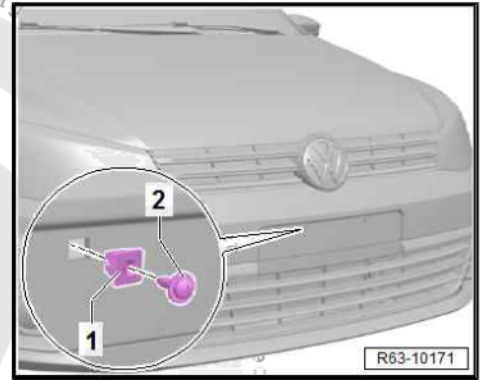


- Use a square file to square the round holes into 7-mm square holes. Install the bushings -1- (both sides).
- Install the screws -2- in both license plate fastening points.

1= Bushing - 301 953 170 2-

2= screw - N 090 179 4-

Correspondence: ➤ Electronic Parts Catalogue "ETKA" .





2 Rear bumper (Fox / Crossfox)

2.1 Rear protector - assembly overview

1 - Nut

- ☐ 2 units
- ☐ Torque: 6.5 Nm

2 - Rear protector

- ☐ Remove and install
⇒ [page 111](#)

3 - Rear wheel case protector

- ☐ Remove and install
⇒ [page 263](#)

4 - Bolt

- ☐ Torque: 1.5 Nm

5 - Bolt

- ☐ Torque: 6.5 Nm

6 - Bolt

- ☐ Torque: 6.5 Nm

7 - Pop rivet nut

- ☐ 6 units
- ☐ Install with the POP
NUT rivet nut applicator
- VAG 1765B- or POP
NUT rivet nut applicator
- EQ 7422- .

8 - Sensor sealing

9 - Parking sensor - G203 /
G204 / G205 / G206-

10 - Support for the Parking
auxiliary sensor - G203 /
G204 / G205 / G206-

11 - Double-sided adhesive
tape

- ☐ The adhesive tape adhesion area must be completely free of dirt.
- ☐ Under no circumstances should the self-adhesive surface of the tape be touched.

12 - Adhesive area for the support of the Parking auxiliary sensor - G203 / G204 / G205 / G206-

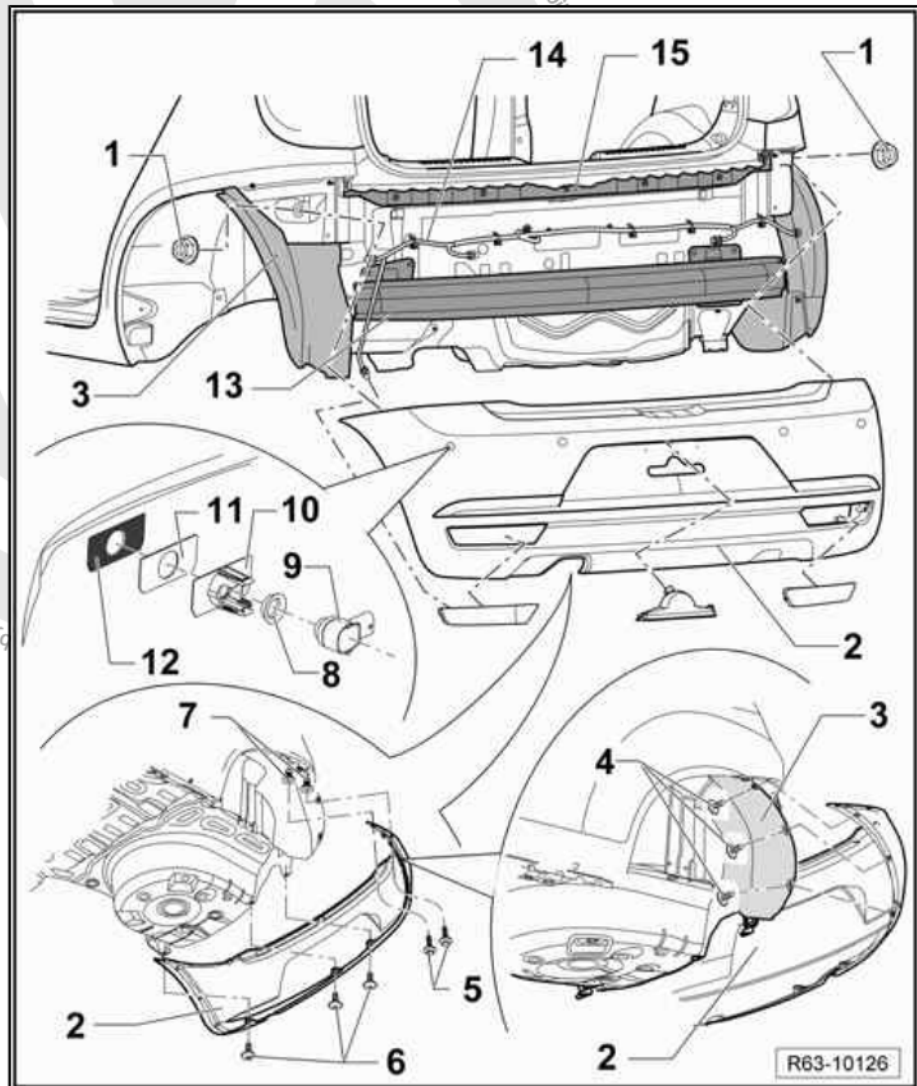
13 - Rear protector support

- ☐ Remove rear protector ⇒ [page 113](#) .

14 - License plate light harness, of parking aid sensors - G203 / G204 / G205 / G206- and fog light

15 - Rear protector fitting support

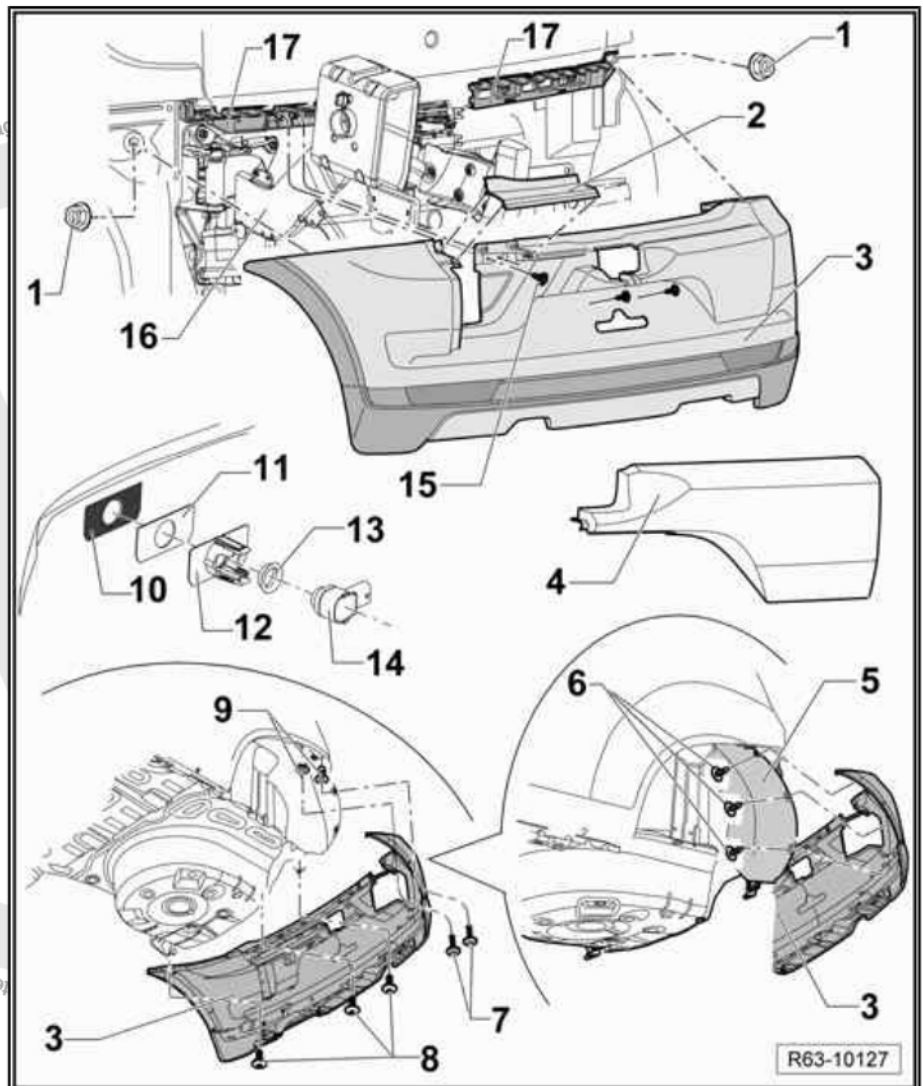
- ☐ Remove rear protector ⇒ [page 111](#) .





2.2 Rear protector (Crossfox) - assembly overview

- 1 - Nut
 - ☐ 2 units
 - ☐ Torque: 6.5 Nm
- 2 - Cover
- 3 - Rear protector
 - ☐ Remove and install
⇒ [page 111](#)
- 4 - Remove spare wheel support
- 5 - Rear wheel case protector
 - ☐ Remove and install
⇒ [page 264](#)
- 6 - Bolt
 - ☐ Torque: 1.5 Nm
- 7 - Bolt
 - ☐ Torque: 6.5 Nm
- 8 - Bolt
 - ☐ Torque: 6.5 Nm
- 9 - Pop rivet nut
 - ☐ 6 units
 - ☐ Install with the POP
NUT rivet nut applicator
- VAG 1765B- or POP
NUT rivet nut applicator
- EQ 7422-
- 10 - Adhesive area for the support of the Parking auxiliary sensor - G203 / G204 / G205 / G206-
- 11 - Double-sided adhesive tape
 - ☐ The adhesive tape adhesion area must be completely free of dirt.
 - ☐ Under no circumstances should the self-adhesive surface of the tape be touched.
- 12 - Support for the Parking auxiliary sensor - G203 / G204 / G205 / G206-
- 13 - Sensor sealing
- 14 - Parking sensor - G203 / G204 / G205 / G206-
- 15 - Bolt
 - ☐ Torque: 1.5 Nm
- 16 - Spare wheel support
 - ☐ Remove and install ⇒ [page 278](#)
- 17 - Rear protector fitting support
 - ☐ Remove rear protector ⇒ [page 111](#) .

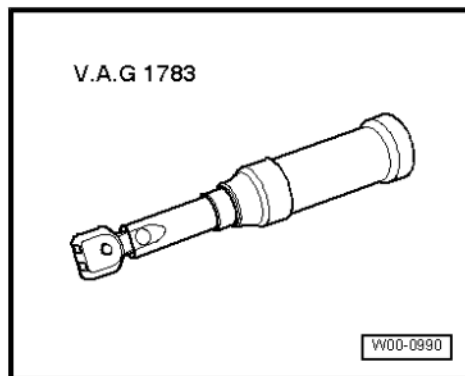


2.3 Rear protector (Fox) - remove and install

Special tools and workshop equipment required



- ◆ Torque wrench 2 to 10 Nm - VAG 1783-



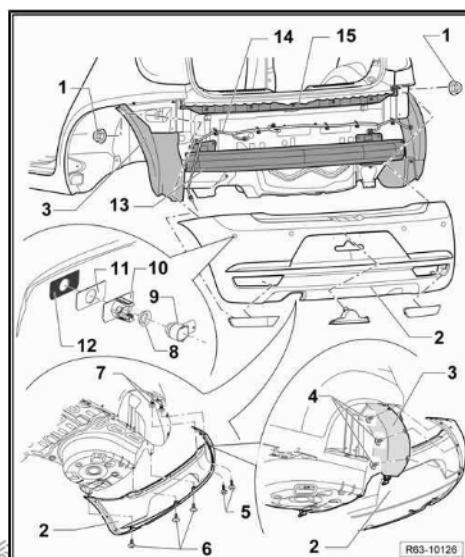
Removal:

- Remove screws -4- from wheel case protectors -3-.
- Remove screws -5- and remove hexagonal nuts -1-; in order to do that move the wheel case protector aside.
- Remove the bolts -6-.
- Carefully pull rear protector -2- and disengage from support -15-.
- Disconnect the electrical harness -14- from the license plate light, from the parking aid sensors - G203 / G204 / G205 / G206- and from the fog light.

Installation:

Install is performed in the reverse sequence, observing the following:

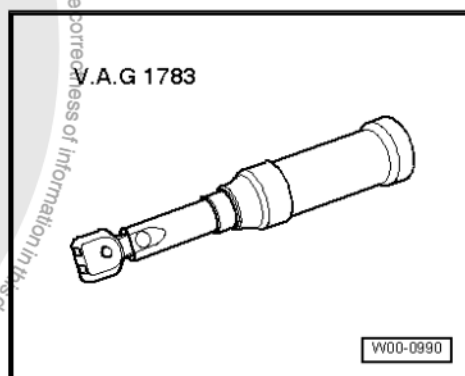
- Connect the electrical harness -14- from the number plate light, from the parking aid sensors - G203 / G204 / G205 / G206- and from the fog light.
- Carefully push rear protector -2- and fit in the support -15-.
- Manually fasten the hexagonal nuts -1-.
- Manually fasten screws -5- and -6-.
- Align rear protector -6- and check clearances ⇒ Body Repairs, Rep. gr. 00 ; Technical data
- Definitely fasten screws -6-, -5-, -4- and hexagonal nuts -1-.



2.4 Rear protector (Crossfox) - remove and install

Special tools and workshop equipment required

- ◆ Torque wrench 2 to 10 Nm - VAG 1783-





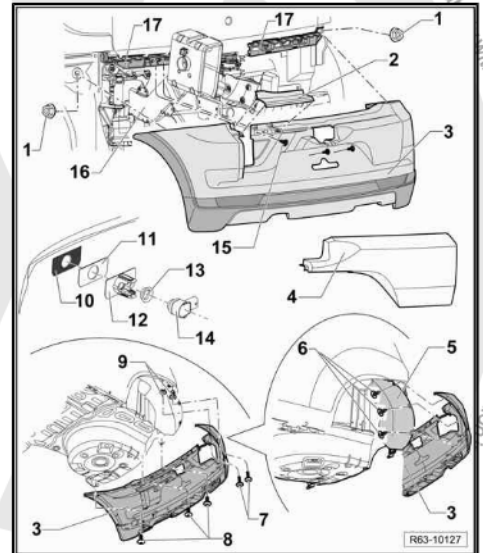
Removal:

- Remove screws -6- from wheel case protectors -5-.
- Remove screws -7- and remove hexagonal nuts -1-; in order to do that move the wheel case protector aside.
- Remove the bolts -8-.
- Move spare wheel support -16- to access the cover -2-.
- Remove cover -2- and screws -15-.
- Carefully pull rear protector -3- and disengage from support.
- Disconnect electrical harness from license plate light, parking aid sensors - G203 / G204 / G205 / G206- , and fog light.

Installation:

Install is performed in the reverse sequence, observing the following:

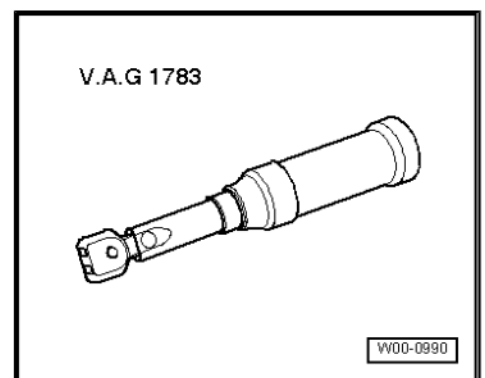
- Connect electrical harness from license plate light, parking aid sensors - G203 / G204 / G205 / G206- , and fog light.
- Carefully pull rear protector -3- and engage into support.
- Manually fasten the hexagonal nuts -1-.
- Manually fasten screws -7- , -8- , -6- and -15-.
- Align rear protector -3- and check the clearances ⇒ Body Repairs; Rep. gr. 00 ; Technical data
- Tighten the screws -7-, -8-, -6-, -15-, and the hexagonal nuts -1-.
- Install the cover -2-.



2.5 Rear protector support (Fox) - remove and install

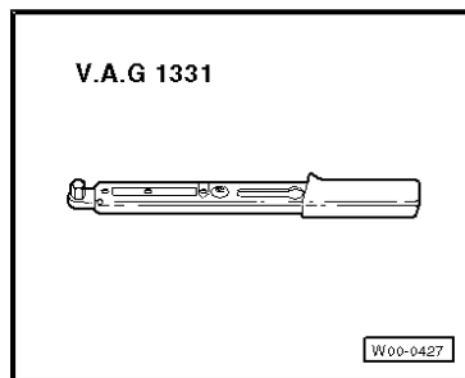
Special tools and workshop equipment required

- ◆ Torque wrench 2 to 10 Nm - VAG 1783-

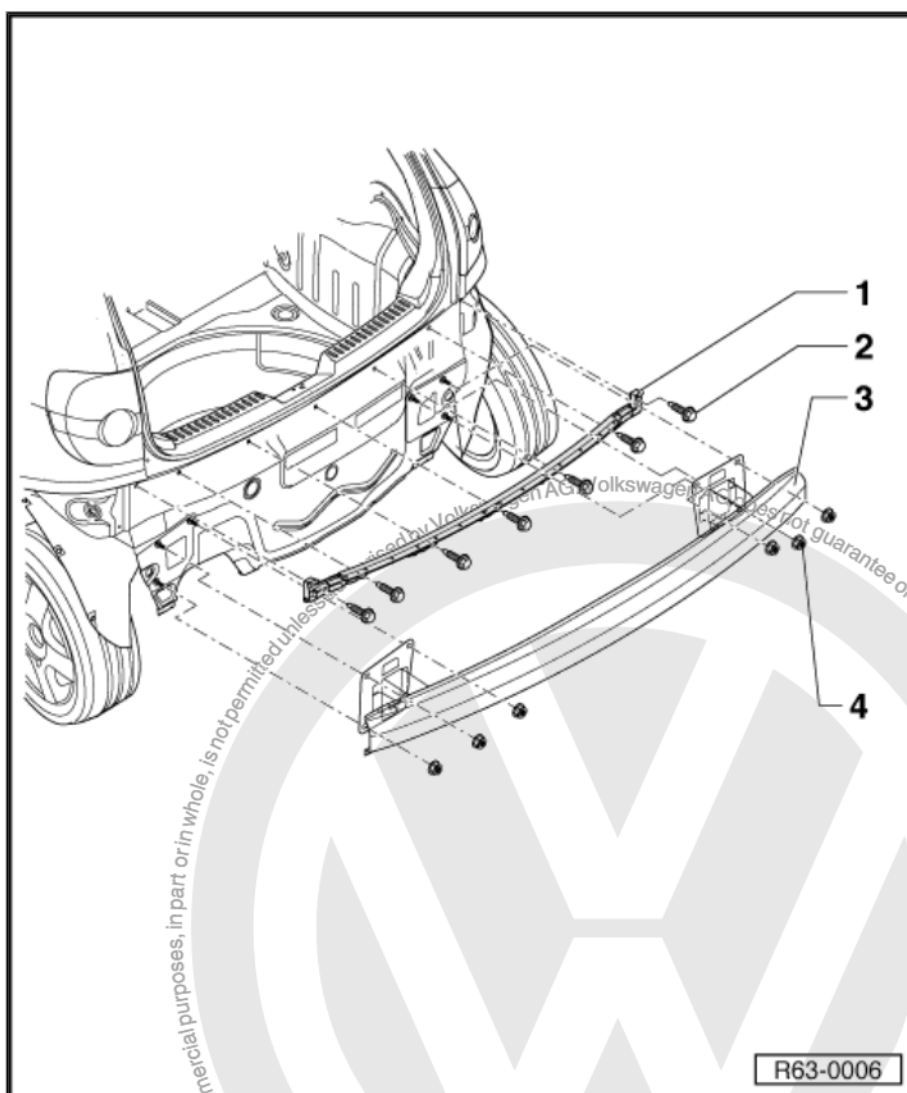




- ◆ Torque wrench - 5 to 50 Nm (1/2" drive) - VAG 1331-



- 1 - Protector support
- 2 - Bolt
 - 7 units
 - Torque: 3 Nm
- 3 - Rear protector support
 - Remove rear protector
⇒ [page 111](#)
- 4 - Hexagonal nut
 - 6 units
 - Torque: 20 Nm



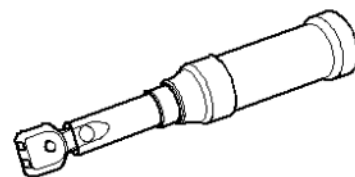
2.6 Rear protector support (Crossfox) - remove and install

Special tools and workshop equipment required



- ◆ Torque wrench 2 to 10 Nm - VAG 1783-

V.A.G 1783



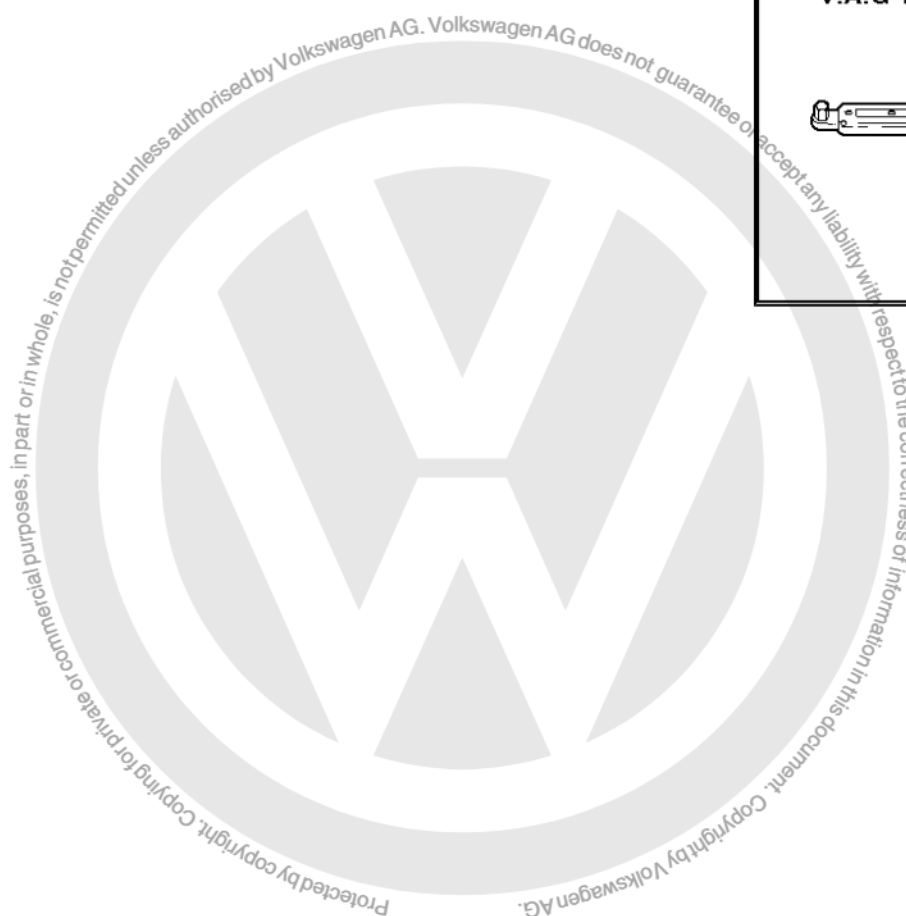
W00-0990

- ◆ Torque wrench - 5 to 50 Nm (1/2" drive) - VAG 1331-

V.A.G 1331



W00-0427





1 - Pop rivet nut

- ☐ To install, use the riveted nut applicator POP NUT - VAG 1765B- or riveted nut applicator POP NUT - EQ 7422-

2 - Protector support

3 - Bolt

- ☐ 6 units
- ☐ Torque: 3 Nm

4 - Hexagonal nut

- ☐ 3 units
- ☐ Torque: 20 Nm

5 - Rear protector support

- ☐ Remove
 - Remove rear protector ➔ [page 112](#) .
 - Remove spare wheel support internal lining.
 - Disconnect harness clamps from connectors of: spare wheel locking motor - V340- and spare wheel unlocking switch on support - E727- .
 - Remove nuts -4- and screws -6-.

6 - Bolt

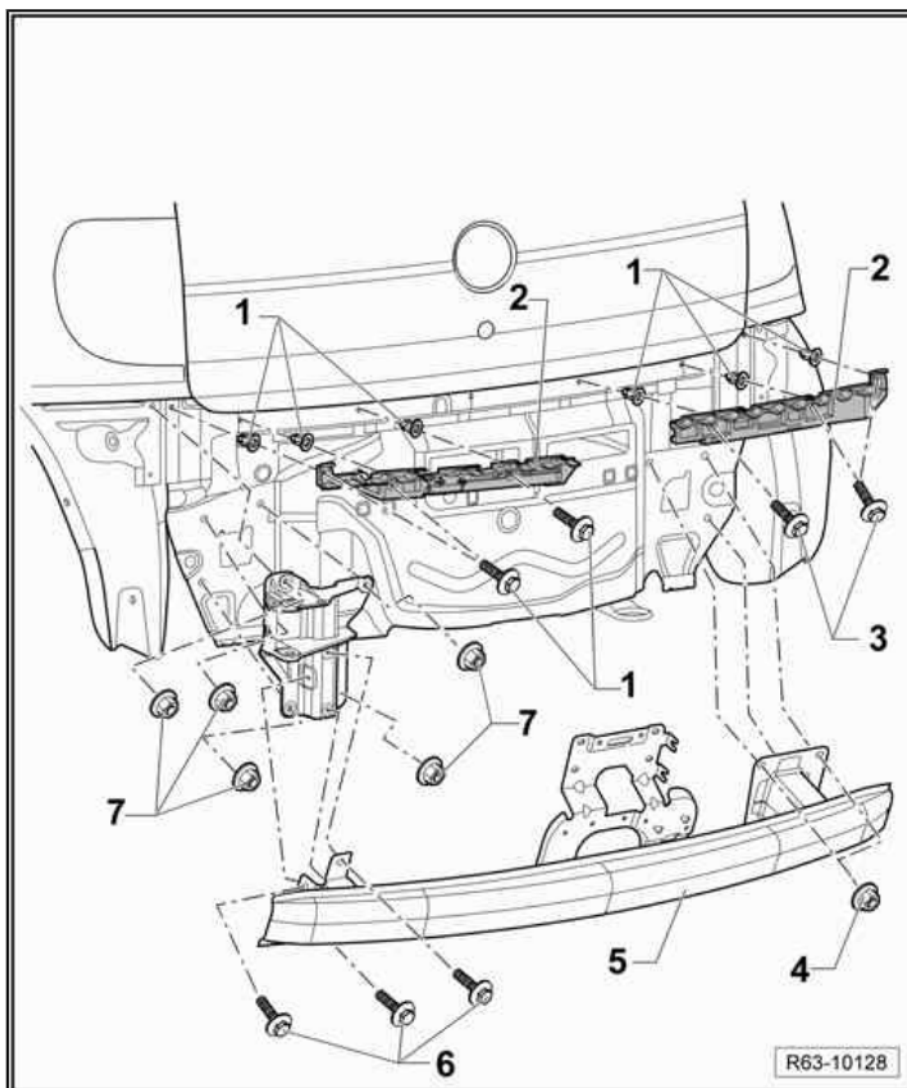
- ☐ 3 units
- ☐ Torque: 20 Nm

7 - Hexagonal nut

- ☐ 5 units
- ☐ Torque: 20 Nm

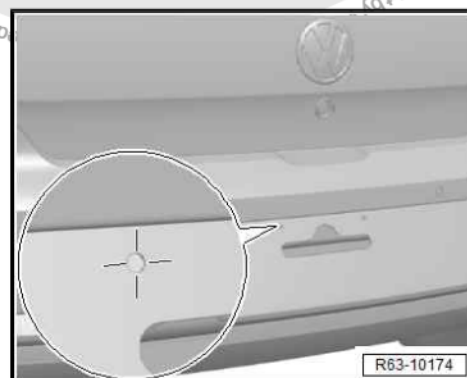
8 - Spare wheel support

- ☐ Remove and install ➔ [page 278](#)



2.7 Fastening of the rear license plate - install

- Use a 6-mm drill bit to drill the holes at the predefined points of the rear protector. Protect adjacent areas with masking tape.



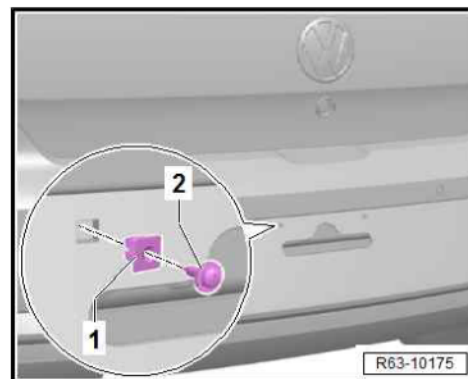


- Use a square file to square the round holes into 7-mm square holes. Install the bushings -1- (both sides).
- Install the screws -2- in both license plate fastening points.

1= Bushing - 301 953 170 2-

2= screw - N 090 179 4-

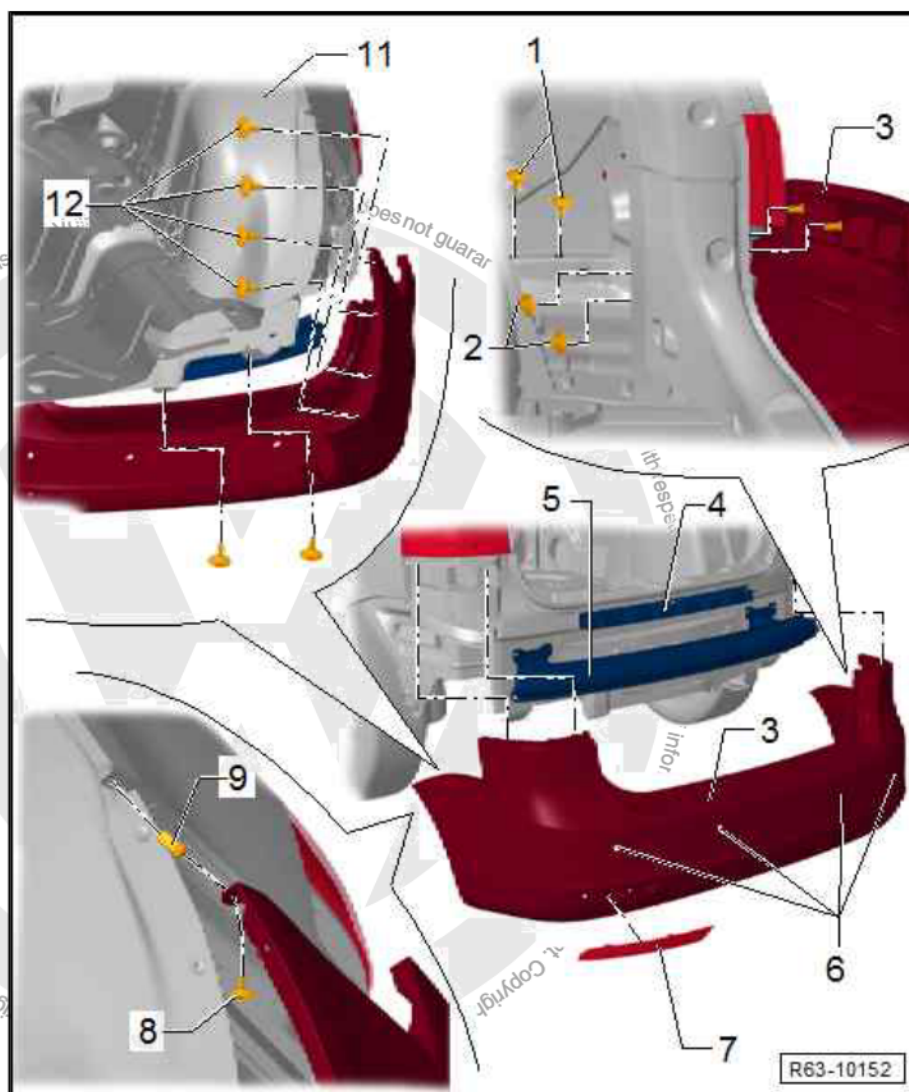
Correspondence: ⇒ Electronic Parts Catalogue "ETKA" .



3 Rear bumper (Spacefox / Suran)

3.1 Rear bumper - assembly overview

- 1 - Bolt
 - ☐ 4 units
 - ☐ Torque: 6.5 Nm
- 2 - Combined nut
 - ☐ 4 units
 - ☐ Torque: 6.5 Nm
- 3 - Rear protector
 - ☐ Remove and install ➔ [page 119](#)
- 4 - Rear protector fitting support
 - ☐ Remove rear protector .
- 5 - Rear protector support
 - ☐ Remove rear protector .
- 6 - Parking sensor - G203 / G204 / G205 / G206-
 - ☐ ➔ Electrical system; Rep. gr. 94 ; Switches, lights and external lamps; Parking aid sensor G203 / G204 / G205 / G206 - remove and install .
- 7 - Retro-reflector
 - ☐ ➔ Electrical equipment; Rep. gr. 94 ; Switches, lights, and external lamps; Retro-reflector - remove and install .
- 8 - Bolt
 - ☐ 2 units
 - ☐ Torque: 1.5 Nm
- 9 - Plastic bushing
 - ☐ 2 units
- 10 - Bolt
 - ☐ 4 units
 - ☐ Torque: 6.5 Nm
- 11 - Rear wheel case protector
 - ☐ Remove and install ➔ [page 265](#)
- 12 - Bolt
 - ☐ 8 units
 - ☐ Torque: 1.5 Nm





3.2 Rear protector - remove and install

Removal:

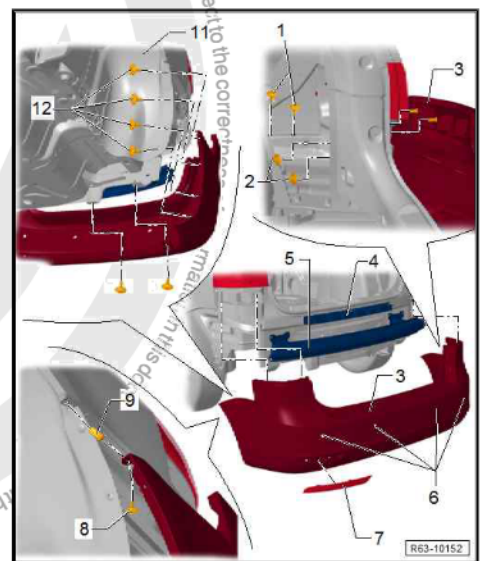
- Remove the bolts -12- (8 parts).
- Remove the bolts -8- (2 parts).
- Remove the bolts -10- (4 parts).
- Remove the lining from the luggage compartment side cover .
- Remove the bolts -1- (4 parts).
- Remove nuts -2- (4 units).
- With the help of a second operator, pull the rear protector from both sides at the same time, to disengage the fitting support -4-.
- Disengage protector -3- from rear support -5-.
- Disengage connector from harness of parking aid senders - G203 / G204 / G205 / G206- .

Installation:



Note

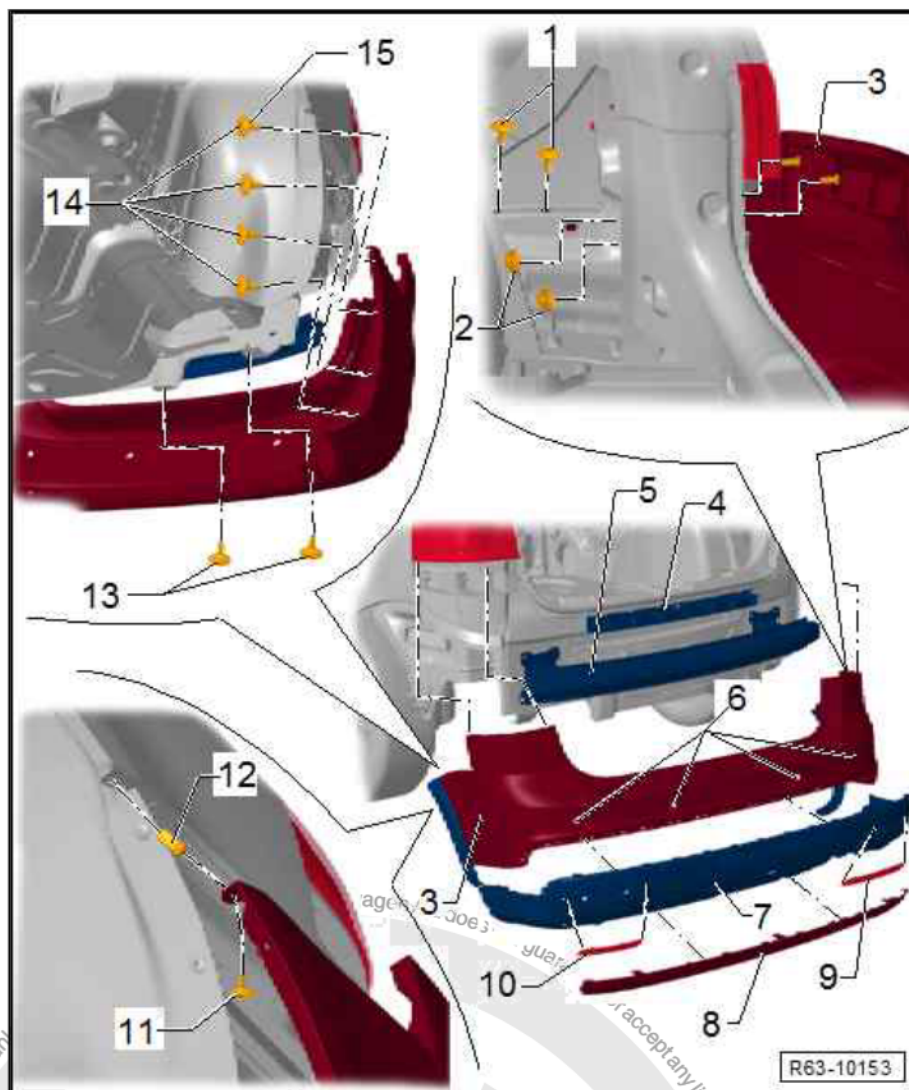
- ◆ *The rear protector and parking aid senders - G203 / G204 / G205 / G206- supplied by Parts and accessories have already a base primer coating, and needs just finishing paint.*
- ◆ *Paint the protector ⇒ Paint Manual - Paint repairs on plastic parts in case of replacement.*
- ◆ *Install the retro-reflector after painting the protector and install the parking aid sensors - G203 / G204 / G205 / G206- .*
- Installation is performed in the reverse sequence to the removal.
- Check clearance dimensions ⇒ Body Repairs; Rep. gr. 00 ; Technical data; Body clearance dimensions before applying torque to bolts.



3.3 Rear bumper (Space Cross / Suran Cross) - assembly overview



- 1 - Bolt
 - ☐ 4 units
 - ☐ Torque: 6.5 Nm
- 2 - Combined nut
 - ☐ 4 units
 - ☐ Torque: 6.5 Nm
- 3 - Rear protector
 - ☐ Remove and install
⇒ [page 121](#)
- 4 - Rear protector fitting support
 - ☐ Remove rear protector .
- 5 - Rear protector support
 - ☐ Remove rear protector .
- 6 - Parking sensor - G203 / G204 / G205 / G206-
 - ☐ ⇒ Electrical system;
Rep. gr. 94 ; Switches,
lights and external
lamps; Parking aid sen-
sor G203 / G204 /
G205 / G206 - remove
and install
- 7 - Rear spoiler with identifica-
tion
- 8 - Rear spoiler
- 9 - Tow hook cover
- 10 - Retro-reflector
 - ☐ ⇒ Electrical equipment;
Rep. gr. 94 ; Switches,
lights, and external
lamps; Retro-reflector -
remove and install
- 11 - Bolt
 - ☐ 2 units
 - ☐ Torque: 1.5 Nm
- 12 - Plastic bushing
 - ☐ 2 units
- 13 - Bolt
 - ☐ 4 units
 - ☐ Torque: 6.5 Nm
- 14 - Rear wheel case protector
 - ☐ Remove and install ⇒ [page 265](#)
- 15 - Bolt
 - ☐ 8 units
 - ☐ Torque: 1.5 Nm





3.4 Rear protector (Space Cross / Suran Cross) - remove and install

Removal:

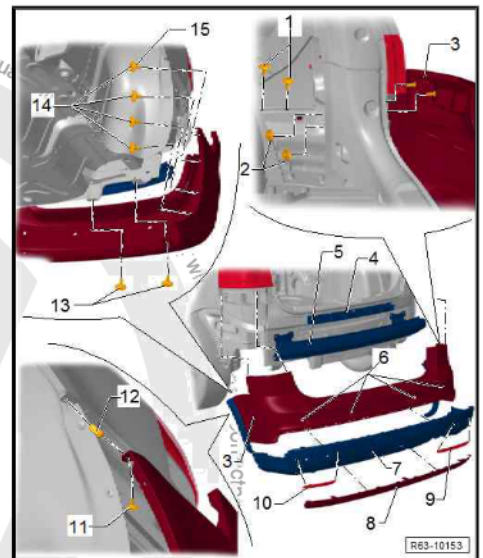
- Remove the bolts -15- (8 parts).
- Remove the bolts -11- (2 parts).
- Remove the bolts -13- (4 parts).
- Remove the lining from the luggage compartment side cover .
- Remove the bolts -1- (4 parts).
- Remove nuts -2- (4 units).
- With the help of a second operator, pull the rear protector from both sides at the same time, to disengage the fitting support -4-.
- Disengage protector -3- from rear support -5-.
- Disengage connector from harness of parking aid senders - G203 / G204 / G205 / G206-

Installation:



Note

- ◆ *The rear protector and parking aid senders - G203 / G204 / G205 / G206- supplied by Parts and accessories have already a base primer coating, and need just finishing paint.*
- ◆ *Paint the protector ⇒ Paint Manual - Paint repairs on plastic parts in case of replacement.*
- ◆ *Install the retro-reflector after painting the protector and install the parking aid senders - G203 / G204 / G205 / G206-*
- Installation is performed in the reverse sequence to the removal.
- Check the clearance dimensions ⇒ Body Repairs; Rep. gr. 00 ; Technical data; Body clearance dimensions before applying torque to bolts.



3.5 Rear protector support - assembly overview



1 - Pop rivet nut M5

- ☐ 3 units
- ☐ Install with the POP NUT rivet nut applicator - VAG 1765B- or POP NUT rivet nut applicator - EQ 7422- .

2 - Rear protector support

- ☐ Remove rear protector .

3 - Bolt

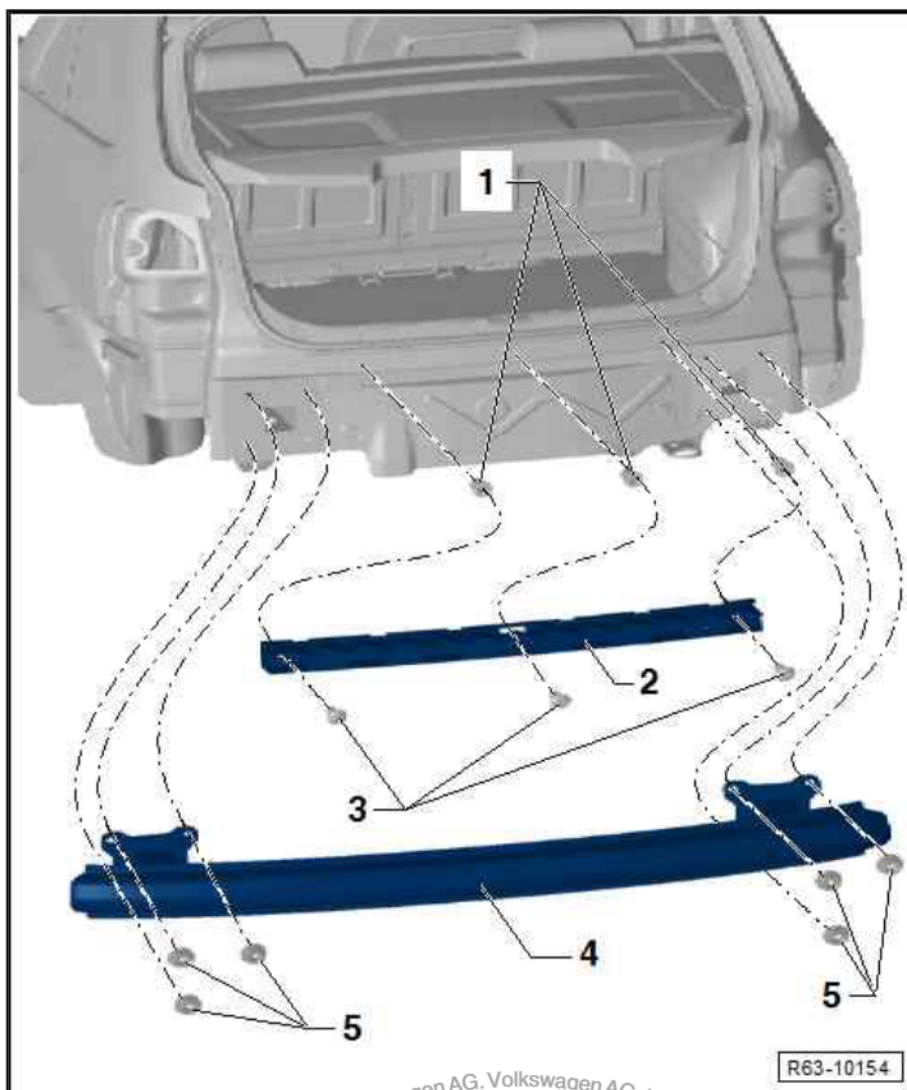
- ☐ 3 units
- ☐ Torque: 3.0 Nm

4 - Rear protector fitting support

- ☐ Remove rear protector .

5 - Nut

- ☐ 6 units
- ☐ Torque: 20 Nm



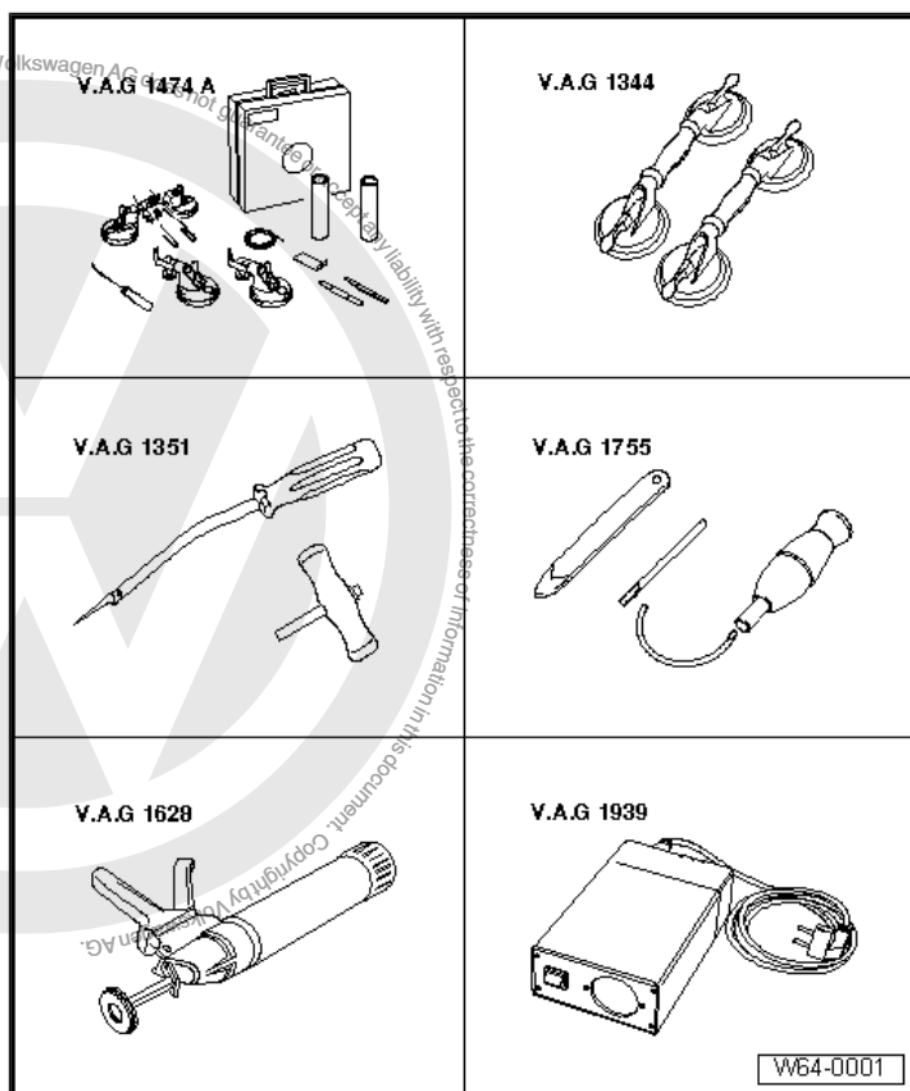


64 – Glazing

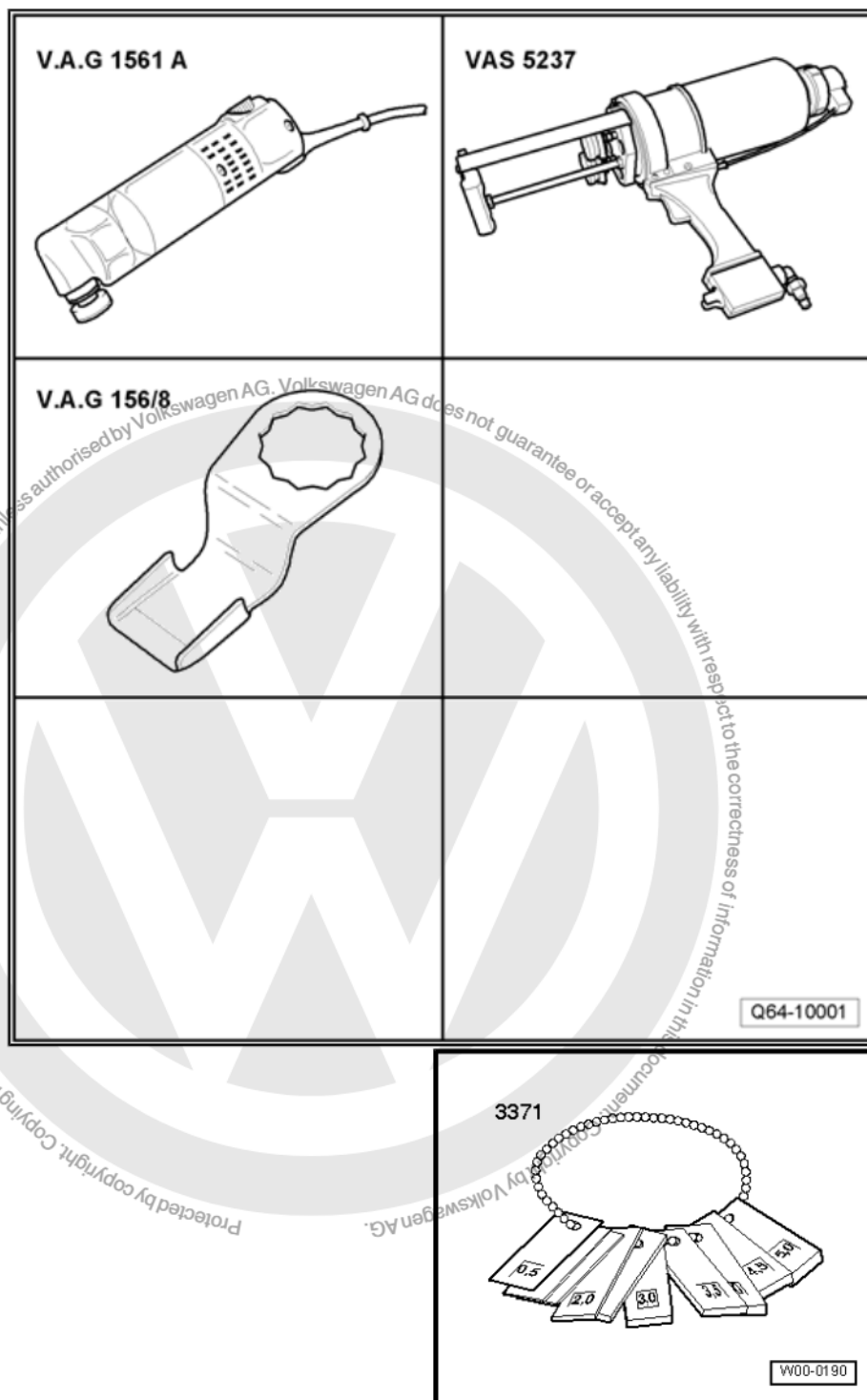
1 Glasses glued with adhesive

1.1 Tools

Special tools and workshop equipment required



- ◆ Glued glass removal kit - VAG 1474B-
- ◆ Suction pads - V.A.G 1344-
- ◆ Anchoring tool - VAG 1351- and Handle - VAG1351/1-
- ◆ Glass removal kit - V.A.G 1755-
- ◆ Manual pressure gun - V.A.G 1628-
- ◆ Device with ratchet - VAG 1654A-
- ◆ Panel protection film - VAG 1474/8-
- ◆ Cartridge heater - V.A.G 1939-



- ◆ Electric window bond cutter - VAG 1561A-
- ◆ 15 mm blade - VAG 1561/8-
- ◆ Pneumatic adhesive applicator - VAS 5237-
- ◆ Adjustment gauge - 3371-

1.2 Auxiliary materials for Brazilian market

- ◆ Glass adhesion kit
⇒ Chemicals Manual;
Rep. gr. 00 ; Chemicals
Manual - List of author-
ized products ^{1, 3, 4}



- ◆ Cutting wire 357 853 999 A
- ◆ Glass adjustment shim 443 845 631 A ²
- ◆ Cleaning solution D 009 401 04 ³

7) Exclusive option for the Brazilian market. The Kit includes (U-400 HV) 310 ml cartridge, primer (primer 5404 A), activator / glass cleaner (primer 5500).

8) It must be removed two hours after assembling the windscreen.

9) Observe the procedural indications in accordance with the manufacturer's prescriptions for packaging disposal

10) Follow the minimum curing time ⇒ [page 142](#) .

1.3 Auxiliary materials for export market



WARNING

- ◆ *When handling chemicals follow the safety instructions ⇒ Chemical Products Manual; Rep. gr. 00*
- ◆ *Assignment of Chemical Materials ⇒ Electronic Parts Catalogue "ETKA"*

- ◆ 1K- Glass adhesive DH 009 100 ^{1, 2, 3, 4, 6}
- ◆ Activator D 181 801 A1 or D 181 801 M1 ^{1, 5}
- ◆ Glass / body primer D 009 200 02 ^{1, 2, 3}
- ◆ Cleaning solution D 009 401 04 ^{1, 4}
- ◆ Primer applicator D 009 500 25
- ◆ Adhesive remover D 002 000 A2 ^{1, 4}
- ◆ Cutting wire 357 853 999 A
- ◆ Glass adjustment shim 443 845 631 A ⁵

11) Exclusive option for the export markets.

12) Heat with the cartridge heater - V.A.G 1939- according to the manufacturer's instructions.

13) Small 110 ml cartridge, for sealing jobs, and/or when the double cartridge with 300 ml is not enough.

14) Observe the procedural indications in accordance with the manufacturer's prescriptions for packaging disposal

15) It must be removed two hours after assembling the windscreen.

16) Follow minimum adhesive curing time ⇒ [page 142](#) .

1.4 Matching table



WARNING

- ◆ *When handling chemicals follow the safety instructions ⇒ Chemical Products Manual; Rep. gr. 00*
- ◆ *Assignment of Chemical Materials ⇒ Electronic Parts Catalogue "ETKA"*



Note

To help understanding, please find below a comparison table for materials used in the Brazilian and export markets

Product	Brazilian Market	Export Market
Activator	Primer 5500	D 181 801 A1 or D 181 801 M1
PU Adhesive	U-400 HV	DH 009 100 - 300 ml
Body primer	Primer 5404 A	D 009 200 02

1.5 Stickers for engraving the VIS number on the windows (only for Brazil) - supply



WARNING

These labels are valid only for the Brazilian market.

The stickers for etching the VIS number on the windows upon request. On the network portal, under "After sales", "Sist. Services Info." the circular number 98/09 from 16/06/2009 "Engraving the chassis number (VIS) on the windows and labels (VIS), wheel housing, B-column and front floor" can be found explaining how to do it.

1.6 Windscreen - Assembly overview



1 - Dimension a = 3 mm

- ☐ Laterally

2 - PUR adhesive bead

- ☐ Adhesive bead cross-section width: -6...0.7 mm-
- ☐ Adhesive bead cross-section height: -9...11 mm- (including base adhesive layer on glass and glass flange)
- ☒ Minimum curing time
⇒ [page 142](#)

3 - Dimension b = 2.5 mm

- ☐ On top

4 - Self-adhesive spacer shim

- ☐ 3 units
- ☐ self-adhesive spacer - 5Z0 845 237-
- ☐ Glue on body before installing the windscreen.

5 - Windscreen

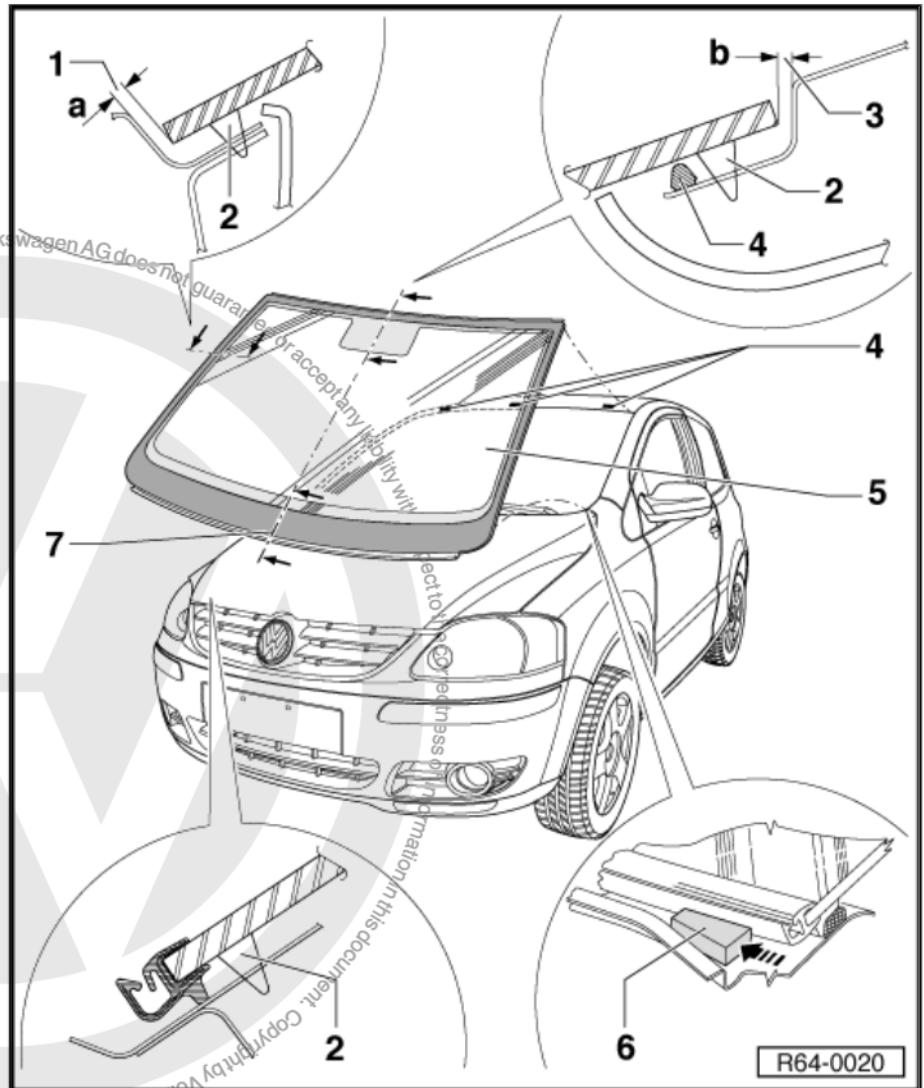
- ☐ Remove and install
⇒ [page 127](#) .
- ☐ Label request for engraving the VIS number on windows (Brazil only)
⇒ [page 126](#)

6 - Glass adjustment shim

- ☐ Replacement parts number -443 845 631 A-
- ☐ Remove after adhesive curing

7 - PUR adhesive cord connection point

- ☐ PU adhesive application start and end.



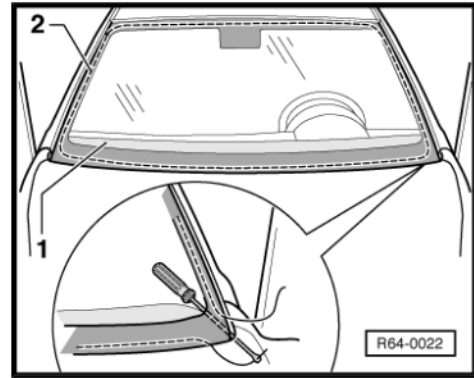
1.7 Windscreen - remove and install

Removal:

- Remove the pillar A linings ⇒ Body - Internal assembly works;
Rep. gr. 70 ; Lining / insulation
- Remove the sunshades ⇒ Body - Internal assembly works;
Rep. gr. 68 ; Internal equipment
- Remove the internal rear-view mirror ⇒ Body - Internal assembly works; Rep. gr. 68 ; Internal equipment



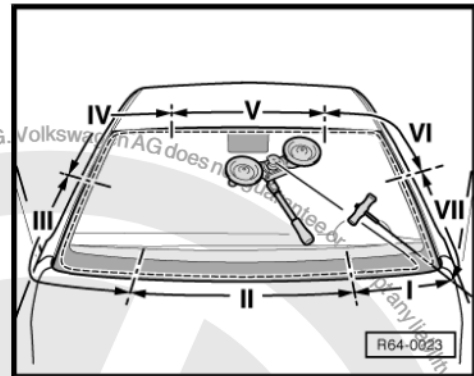
- Insert a protective film on dashboard - VAG 1474/8- -1- - V.A.G 1474/8- between windscreen and dashboard.
- If needed, place the cutting wire -357 853 999.A- -2- with the aid of the tube (from the glass removal kit - V.A.G 1755-) at the glass flange.
- On areas with little clearance, you must distribute the cutting wire on the outside and press under the lip with a plastic wedge .
- Pull the cutting wire -357 853 999.A- with the perforating tool - VAG 1474/2- (from the glued glass removal kit - VAG 1474B-) through the adhesive cord from inside the vehicle.



Note

Lead the perforating tool - VAG 1474/2- on the glass side as close as possible to the body glass flange through the adhesive cord so that the sealing lip is not damaged.

- Fasten the cutting wire tip -357 853 999.A- to the device with ratchet - VAG 1654A- .
- Pull the second cutting wire tip -357 853 999.A- inwards and place the handle (from the anchoring tool - VAG 1351-) to hold it.
- Place the device with ratchet - VAG 1654A- in "position I".
- Transfer the device with ratchet - VAG 1654A- to "position II" as the adhesive gets cut.
- During the cutting (separation), press the cutting wire -357 853 999.A- against the glass with a plastic wedge -VAG 1474/5- to obtain free passage on the glass flange and the dash panel.
- Remove the glass with the suction pads - V.A.G 1344- .



Installation:

Prepare the undamaged glass to be installed ⇒ [page 139](#) .

Prepare the new glass to be installed ⇒ [page 139](#) .

Prepare the body flange for putting the glass ⇒ [page 140](#) .

Assembly instructions ⇒ [page 141](#)

Minimum adhesive curing time ⇒ [page 142](#) .

1.8 Side glasses (Fox -2-door) - assembly overview



1 - Glass internal packing

- ☐ Fitted to the fitting flange
- ☐ In case of replacement, install with slight hits with a rubber hammer
- ☐ Install glass internal packing ⇒ [page 130](#)

2 - Side window

- ☐ Remove side glass ⇒ [page 129](#)
- ☐ Install side glass ⇒ [page 131](#)
- ☐ Label request for engraving the VIS number on windows (Brazil only) ⇒ [page 126](#)

3 - Ceramic painting

- ☐ around glass from internal side

4 - PUR adhesive bead

- ☐ Adhesive bead cross-section width: 7.5...00.80.5 mm
- ☐ Adhesive bead cross-section height: 13...15 mm (including remaining material on glass and glass flange)
- ☐ Minimum curing time ⇒ [page 142](#)

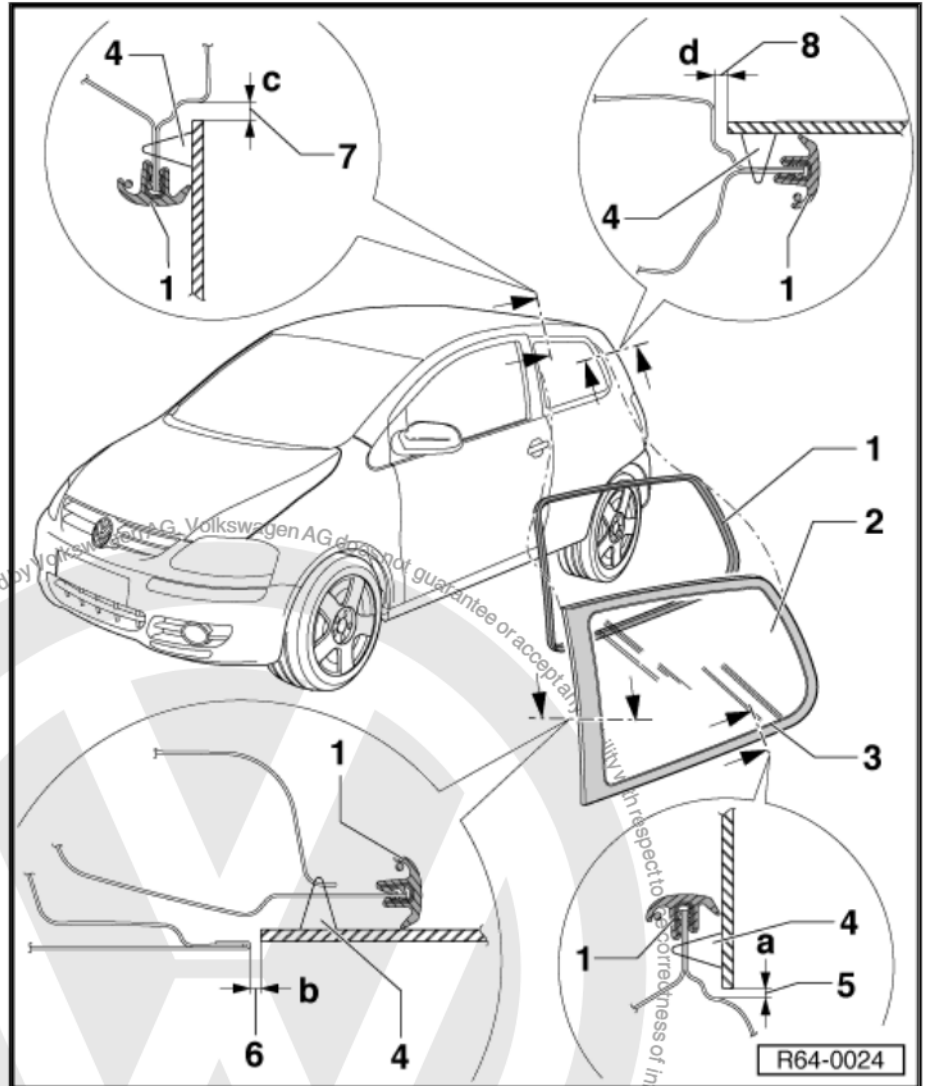
5 - Dimension a = 3 mm

6 - Dimension b = 3 mm

7 - Dimension c = 4.5 mm

- ☐ Clearance dimension must be followed, as the distance is necessary for main roof support fastening

8 - Dimension d = 3 mm

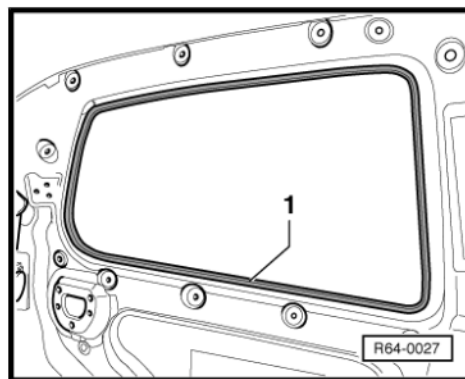


1.9 Undamaged side glass (Fox - 2-door) - remove

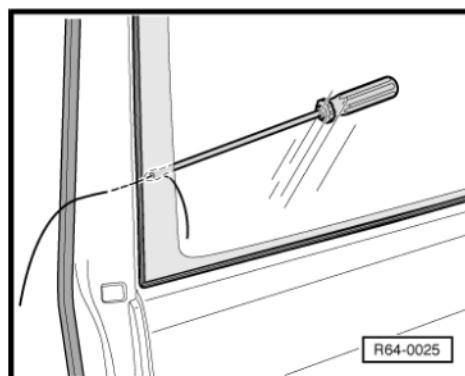
- Remove linings ⇒ General body repairs, interior; Rep. gr. 70 ; Linings / insulations .
- Remove B-pillar linings ⇒ General body repairs, interior; Rep. gr. 70 ; Linings / insulations
- Remove the C-pillar lining ⇒ General body repairs, interior; Rep. gr. 70 ; Linings/insulation



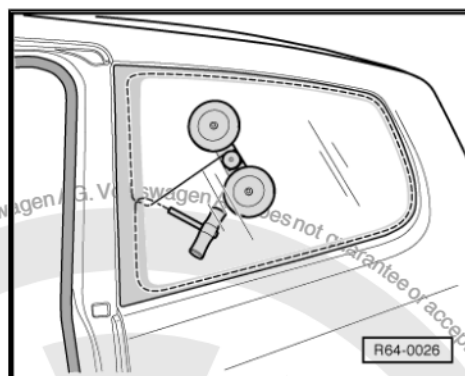
- Remove glass internal packing -1-.



- Pull cutting wire - 357 853 999.A- with perforating tool - VAG 1474/2- (of -V.A.G 1474.B-) through adhesive card to vehicle interior.
- On areas with little clearance, you must distribute the cutting wire -357 853 999.A- on the outside and press under the lip with a plastic wedge .
- Place the cutting wire around the side glass.



- Pull external cutting wire end with a handle VAG 1351/1 using adhesive cord through vehicle interior.
- Fasten the other cutting wire edge in the device with ratchet - VAG 1654A- and cut glass adhesive. Change device with ratchet - VAG 1654A- position until complete adhesive cord cut.
- During the cutting (separation), press the cutting wire end against the glass with the plastic wedge to obtain free passage on the glass flange.



1.10 Damaged side glass (Fox - 2-door) - remove

Removal of damaged side glass is carried out the same way as described for rear glass removal ➔ [page 135](#) .

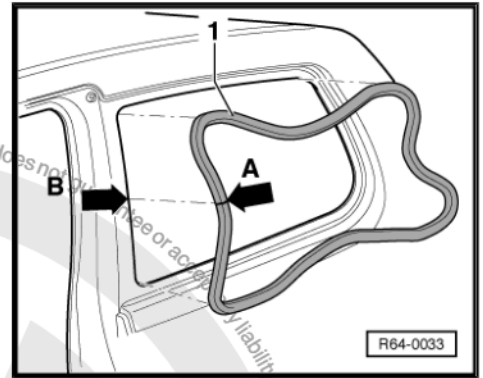
1.11 Side glass internal trim (Fox - 2-door) - install

When replacing packing, install the new part with a rubber hammer.

For partially removed packing, it is necessary to press packing sides before assembly.



- Install side glass internal packing -1- with centered vulcanized splice -arrow A- in window cut flange -arrow B-, and open over flange uniformly.



1.12 Side glass (Fox - 2-door) - install

When placing the side glass, you must maintain a 4.5 mm clearance between the upper glass corner and the glass flange on the side panel. That distance is occasionally necessary for main roof support fastening.

Prepare the undamaged glass to be installed ⇒ [page 139](#) .

Prepare the new glass to be installed ⇒ [page 139](#) .

Prepare the body flange for putting the glass ⇒ [page 140](#) .

Assembly instructions ⇒ [page 141](#) .

Minimum adhesive curing time ⇒ [page 142](#) .

1.13 Side glass (Spacefox / Suran) - assembly overview



1 - PUR adhesive bead

- ☐ Adhesive bead cross-section width: 8...9 mm
- ☐ Adhesive bead cross-section height: 9...11 mm (including remaining material on glass and glass flange)
- ☐ Minimum curing time
⇒ [page 142](#)

2 - Side window

- ☐ Remove non-damaged side window
⇒ [page 133](#)
- ☐ Remove damaged side glass ⇒ [page 133](#)
- ☐ Install side glass
⇒ [page 133](#)
- ☐ Label request for engraving the VIS number on windows (Brazil only)
⇒ [page 126](#)

a = 3 mm

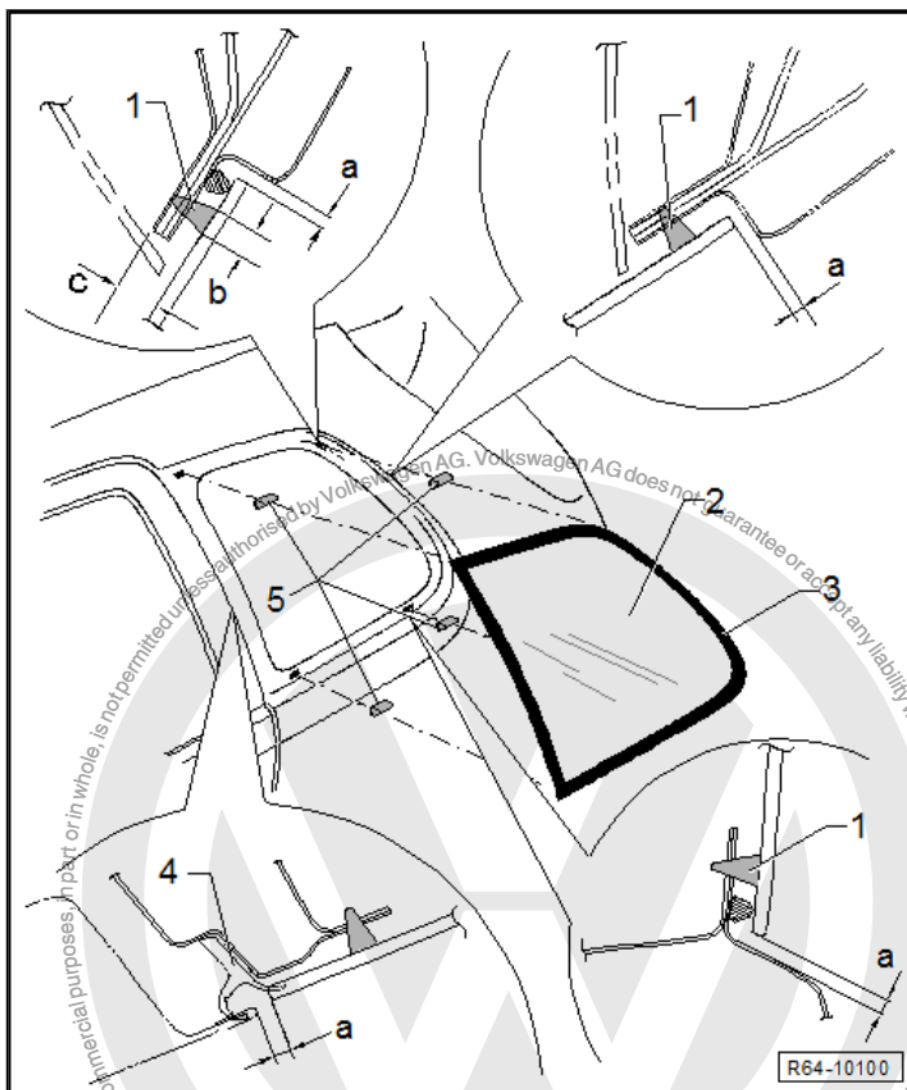
3 - PUR adhesive cord connection point

- ☐ PU adhesive application start and end.

4 - External door trim

5 - Self-adhesive spacer shim

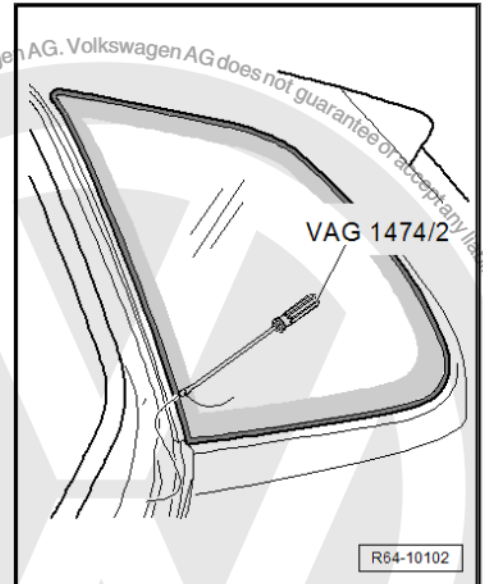
- ☐ 4 units
- ☐ self-adhesive spacer - 5Z0 845 237-
- ☐ Glue on body before installing the glass.



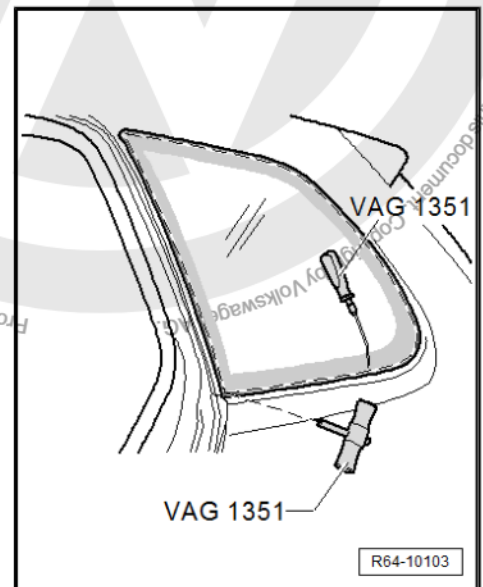


1.14 Undamaged side glass (Spacefox / Suran) - remove

- Remove the C and D-pillar coverings ➔ General body repairs, interior; Rep. gr. 70 ; Lining / insulation .



- Insert the perforating tool - VAG 1474/2- between the glass and the glass frame, perforating the adhesive cord. Insert the cutting wire - 357 853 999 A- in the hole in the tool end, then pull the perforating tool - VAG 1474/2- and bring the wire to inside the vehicle.
- Fasten the cutting wire in the inner anchoring tool - VAG 1351/- , and the outer end with the traction cable - VAG 1351/1- .
- Traction the cutting wire through the traction cable - VAG 1351/1- and successively change the position of anchoring tool - VAG 1351- until cutting the adhesive completely.



1.15 Damaged side glass (Spacefox / Suran) - remove

Removal of damaged side glass is carried out the same way as described for rear glass removal ➔ [page 138](#) .

1.16 Side glass (Spacefox / Suran) - install

When placing the side glass, you must maintain a 3 mm clearance between the upper glass corner and the glass flange on the side panel.

Prepare the undamaged glass to be installed ➔ [page 139](#) .

Prepare the new window to be installed ➔ [page 139](#) .

Prepare the body flange for putting the glass ➔ [page 140](#)

Assembly instructions ➔ [page 141](#)

Minimum adhesive curing time ➔ [page 142](#)



1.17 Rear window (Fox) - assembly overview

1 - Rear window

- ☐ Remove rear window
⇒ [page 134](#)
- ☐ Install rear window
⇒ [page 136](#)
- ☐ Label request for engraving the VIS number on windows (Brazil only)
⇒ [page 126](#)

2 - Defogger terminal

3 - Sealing

- ☐ For rear window wiper
- ☐ Observe assembly position: rabbet facing upwards.

4 - PUR adhesive bead

- ☐ Cord cross-section -b- width: 6...7 mm
- ☐ Cord cross-section -c- height: 9...11 mm (including remaining material on glass and glass flange)
- ☐ Minimum adhesive curing time ⇒ [page 142](#)

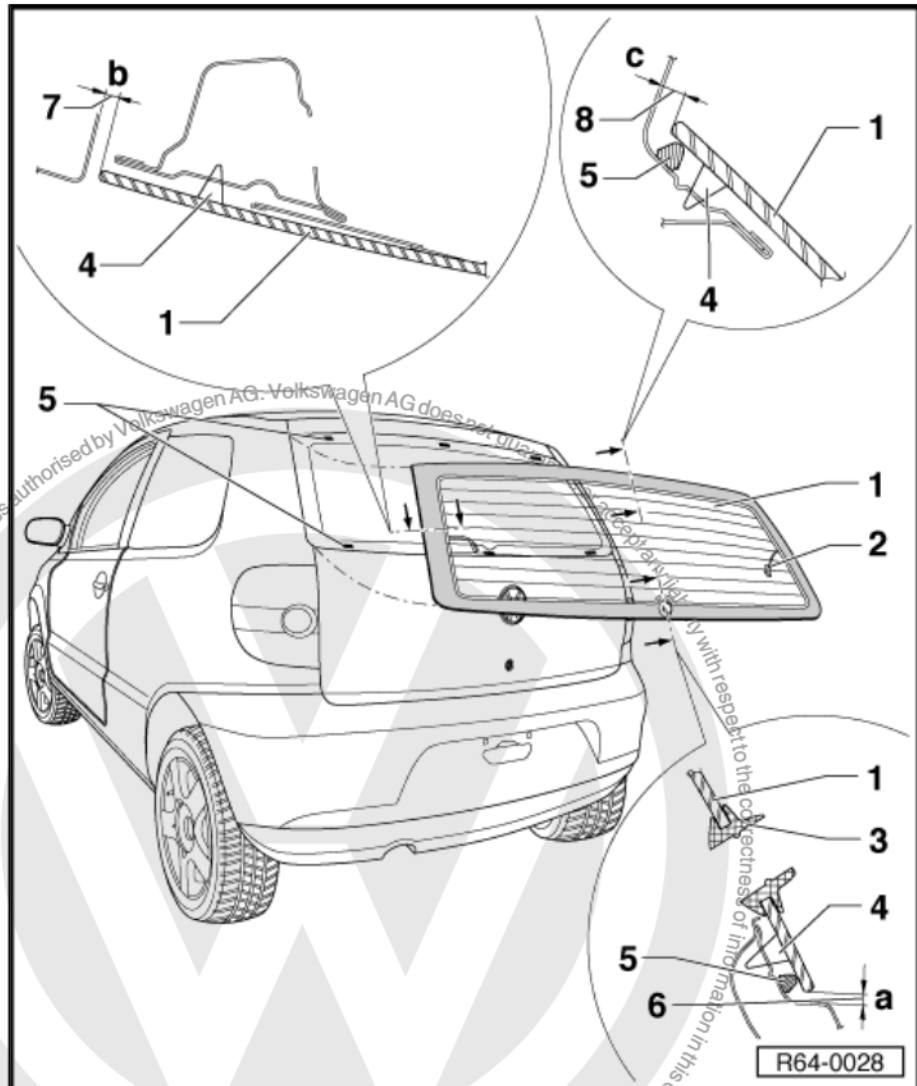
5 - Self-adhesive spacer shim

- ☐ 6 units
- ☐ Self-adherent
- ☐ Glue on body before installing the glass.
- ☐ self-adhesive spacer - 5Z0 845 237-

6 - Dimension a = 3 mm

7 - Dimension b = 4 mm

8 - Dimension c = 3 mm



1.18 Undamaged rear window (Fox) - remove

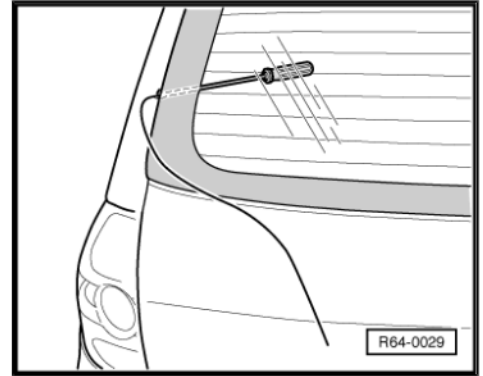
- Remove the rear door lining ⇒ General body repairs, interior; Rep. gr. 70 ; Lining / insulation
- Disconnect rear glass defogger connections and press contact terminals on the glass.
- Remove the additional brake light ⇒ Electrical equipment; Rep. gr. 94 ; Switches, lights and external lamps
- Remove the rear window wiper motor ⇒ Electrical system; Rep. gr. 92 ; Windscreen, rear window and headlight wiper and washer
- If necessary, bend the handle (from - V.A.G 1474.B-) a little downwards to avoid too much tension on the rear window.



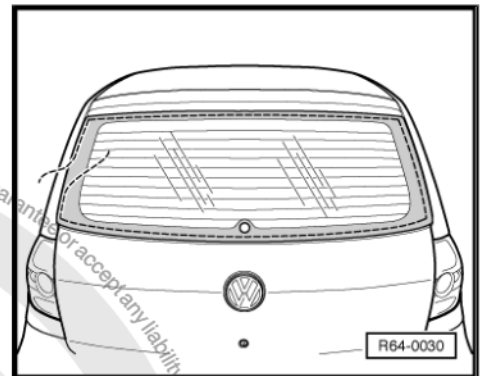
- Slightly open the lid and join the handle to the adhesive cord (use the rear window side area).

The handle must be guided as close as possible to the window.

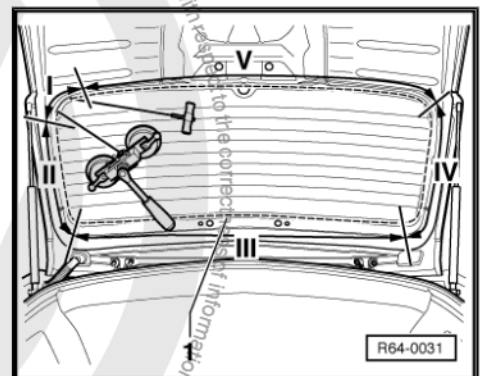
- Pull one end of the cutting wire inwards (use pliers and safety gloves).



- Place the cutting wire around the rear window.
- Pull the external end of the cutting wire inwards and fasten the handle to hold it.



- Mark the entire flange perimeter -1- with reinforced adhesive tape.
- Fasten the ends of the cutting wire to the device with ratchet - VAG 1654A- .
- Place the device with ratchet in "position I".
- Transfer the device with ratchet accordingly and cut (separate) the glass.
- During the cutting, press the cutting wire against the glass with the plastic wedge to obtain free passage on the glass flange.



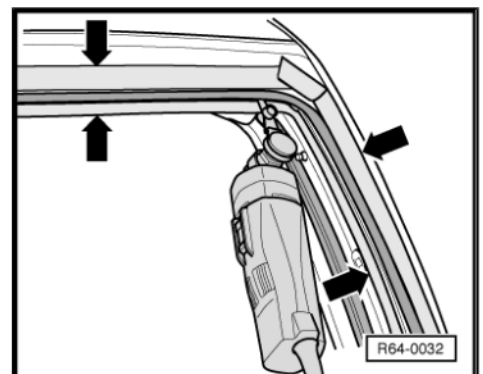
1.19 Damaged rear window (Fox) - remove

- Protect the body and the internal compartment from glass chips.
- Eliminate the glass chips until removing the adhesive sealing material.
- Disconnect glass defogger connections.
- Mark -arrows- the entire flange perimeter and the lid border with reinforced adhesive tape.
- Cut the adhesive (with glass remains) at the glass cut with a blade - VAG 1561/10- (with limiter roll).



DANGER!

It is mandatory to wear safety goggles and safety gloves.





1.20 Rear window (Fox) - install

Prepare the undamaged glass to be installed ⇒ [page 139](#).

Prepare the new glass to be installed ⇒ [page 139](#).

Prepare the body flange for putting the glass ⇒ [page 140](#).

Assembly instructions ⇒ [page 141](#).

Minimum curing time ⇒ [page 142](#).

1.21 Rear glass (Spacefox / Suran) - assembly overview

1 - Rear window

- ☐ Remove non-damaged rear window ⇒ [page 136](#)
- ☐ Remove damaged rear window ⇒ [page 138](#)
- ☐ Install rear window
- ☐ Label request for engraving the VIS number on windows (Brazil only) ⇒ [page 126](#)

a = 3 mm

2 - Sealing

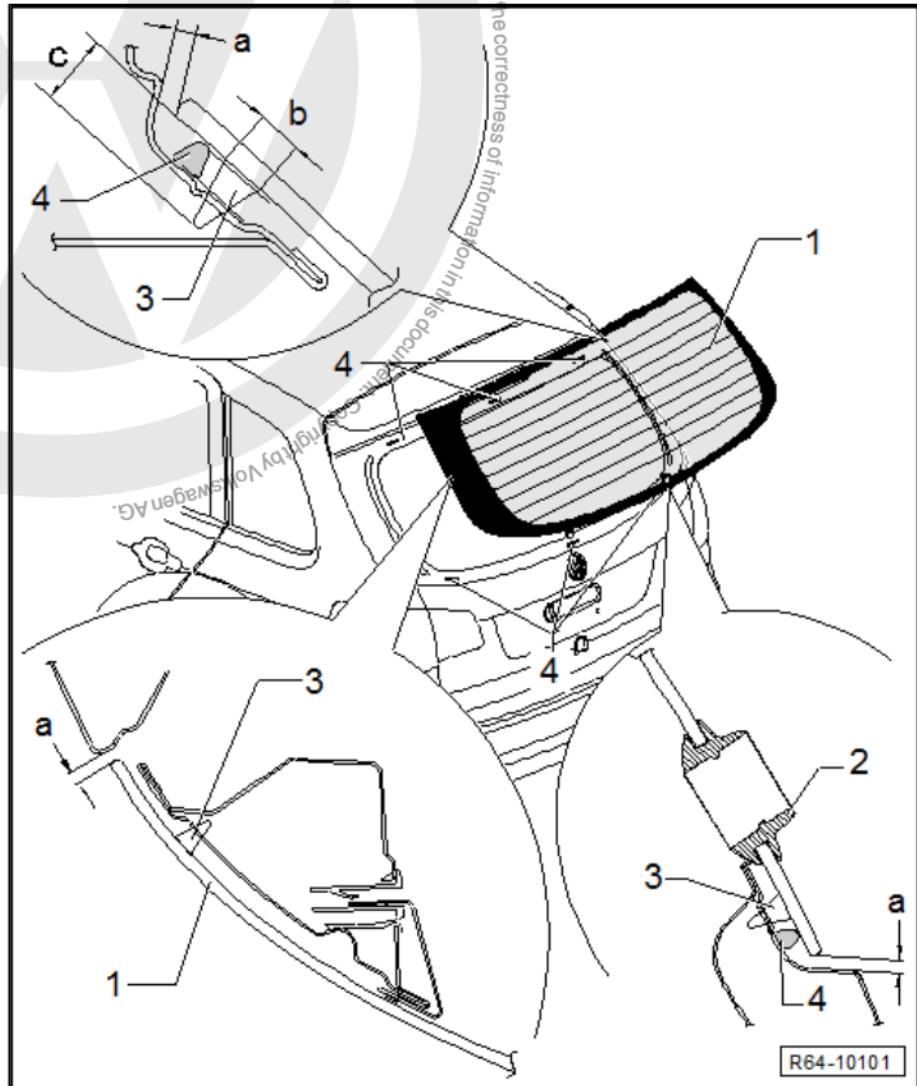
- ☐ For rear window wiper
- ☐ Observe assembly position: rabbet facing upwards.

3 - PUR adhesive bead

- ☐ Cord cross-section -b- width: 6...7 mm
- ☐ Cord cross-section -c- height: 9...11 mm (including remaining material on glass and glass flange)
- ☐ Minimum adhesive curing time ⇒ [page 142](#)

4 - Self-adhesive spacer shim

- ☐ 6 units
- ☐ Self-adherent
- ☐ Glue on rear lid before installing the glass.
- ☐ self-adhesive spacer - 5Z0 845 237-



1.22 Undamaged rear glass (Spacefox / Suran) - remove

- Remove the rear door lining ⇒ General body repairs, interior; Rep. gr. 70 ; Lining / insulation
- Disconnect rear glass defogger connections and press contact terminals on the glass.

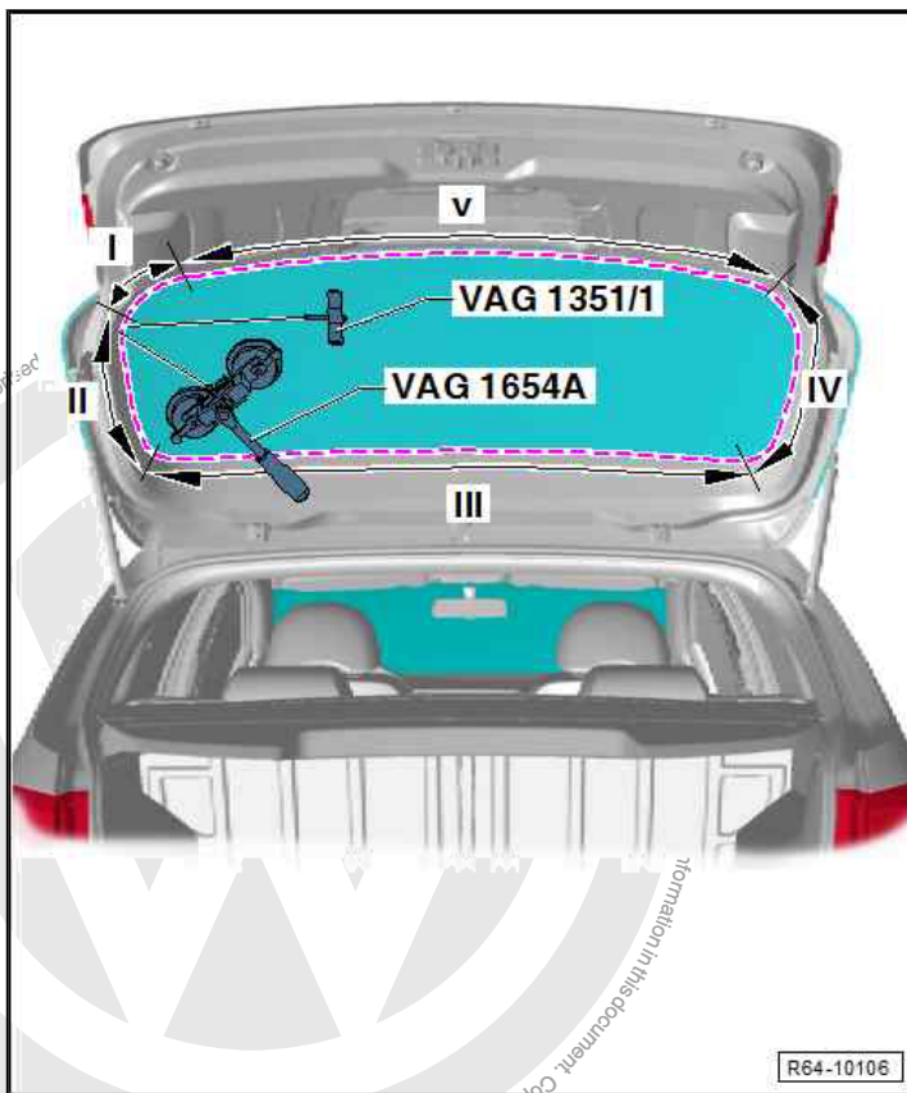


- Remove the additional brake light ⇒ Electrical equipment;
Rep. gr. 94 ; Switches, lights and external lamps
- Remove the rear window wiper motor ⇒ Electrical system;
Rep. gr. 92 ; Windscreen, rear window and headlight wiper
and washer



- Insert the perforating tool - VAG 1474/2- between the glass and the glass frame, perforating the adhesive cord. Insert the cutting wire - 357 853 999 A- in the hole in the tool end, then pull the perforating tool - VAG 1474/2- and bring the wire to inside the vehicle.
- Encircle the entire glass with the cutting wire - 357 853 999 A- .





- Fasten the cutting wire inside the vehicle in the anchoring tool - VAG 1654A-, and the outer end to the traction cable - VAG 1351/1-.
- Place the device with ratchet - VAG 1654A- in "position I", and traction the wire.
- Transfer the device with ratchet - VAG 1654A- to "position II" as the adhesive gets cut.
- During cutting, press the cutting wire -357 853 999.A- against the glass with the plastic wedge -VAG 1474/5- to obtain free passage on the glass flange.
- Traction the cutting wire through the traction cable - VAG 1351/1- and successively change the position of anchoring tool - VAG 1351- until cutting the adhesive completely.
- Remove the glass with the suction pads - V.A.G 1344-.

1.23 Damaged rear glass (Spacefox / Suran) - remove

Prepare the undamaged glass to be installed ⇒ [page 139](#).

Prepare the new glass to be installed ⇒ [page 139](#).

Prepare the body flange for putting the glass ⇒ [page 140](#).



Assembly instructions ➔ [page 141](#) .

Minimum curing time ➔ [page 142](#) .

1.24 Undamaged glass - prepare for install



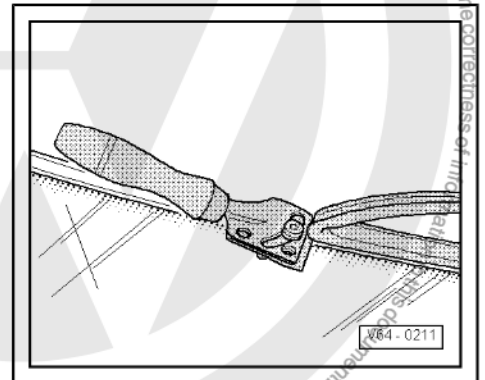
WARNING

- ◆ *When handling chemicals follow the safety instructions ➔ Chemical Products Manual; Rep. gr. 00*
- ◆ *Assignment of Chemical Materials ➔ Electronic Parts Catalogue "ETKA"*



Note

- ◆ *When reusing undamaged glass, reduce the adhesive cord layer to between 1 and 2 mm of height and do not damage the primer and ceramic coats.*
- ◆ *The adhesive bead coat serves as a base for the new adhesive.*
- ◆ *Do not apply primer or cleaning solution to treat the adhesive surface. Keep the adhesion surface free from dirt and grease.*
- ◆ *Exception: If the adhesion is not performed immediately after reducing the coat, then the adhesive cord layer must be activated with the activator - D 181 801 A1 ou D 181 801 M1- with the applicator - D 009 500 25- ..*
- ◆ *The activator must not touch the painted surface, as it will result in damage to the latter. The drying time is approximately 10 minutes.*



1.25 New glass - prepare for install



WARNING

- ◆ *When handling chemicals follow the safety instructions ➔ Chemical Products Manual; Rep. gr. 00*
- ◆ *Assignment of Chemical Materials ➔ Electronic Parts Catalogue "ETKA"*

- Install two suction pads - V.A.G 1344- for glass handling.
- Clean the glass edge throughout about 20 mm of its perimeter with the cleaning solution -D 009 401 04- .
- Rub the glass edge dry with a clean cloth.



Note

For vehicles in the Brazilian market, use primers from the glass gluing kit.



- Apply a thin layer of the activator - D 181 801 A1 / M1- with the applicator - D 009 500 25- -1- (felt sphere with wire) on area -b- of the window only.

- ◆ a = area with ceramic paintwork.
- ◆ b = area for application of the activator and primer.
- ◆ c = area for application of the PU adhesive.

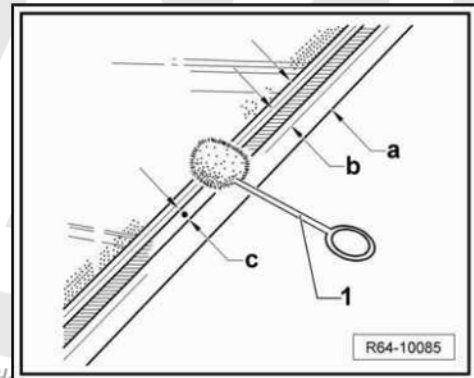
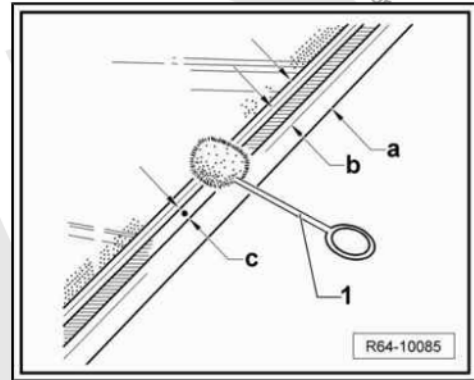
- The drying time of the activator - D 181 801 A1 / M1- is 10 minutes.
- Apply, on area -b-, the primer - D 009 200 02- with the applicator - D 009 500 25- -1- (felt sphere with wire) on area -b- of the window only. The drying time of the primer is 15 minutes.

- ◆ $b = 12 \pm 0.04$ in



Note

- ◆ After applying the primer, the surface cannot be touched under any circumstances.
- ◆ The area -c- is reserved for applying the adhesive bead.



1.26 Body flange - prepare to install the window



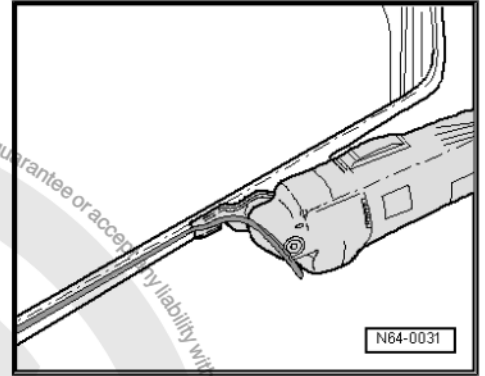
WARNING

- ◆ When handling chemicals follow the safety instructions ⇒ Chemical Products Manual; Rep. gr. 00
- ◆ Assignment of Chemical Materials ⇒ Electronic Parts Catalogue "ETKA"



Note

- ◆ Cut body flange adhesive excess with 15-mm Blade - VAG 1561/8- . Keep a small layer for adhesive cord anchoring.
- ◆ The adhesive bead layer works as a base for the new adhesive bead.
- ◆ Do not apply primer or cleaning solution to the cut adhesive bead surface. Keep the gluing surface free from dirt and grease.
- ◆ The activator must not contact the painting - otherwise, the painting will be damaged.
- ◆ If the adhesion is not performed immediately after reducing the coat, then the adhesive bead layer must be activated with the activator - D 181 801 A1 / M1- . See the corresponding table ⇒ [page 125](#) .
- ◆ If flange has been repainted, apply primer - D 009 200 02- with applicator - D 009 500 25- . See the corresponding table ⇒ [page 125](#) .
- ◆ Glue the self-gluing buffer spacers - 5Z0 845 237- to the flange of the window frame.

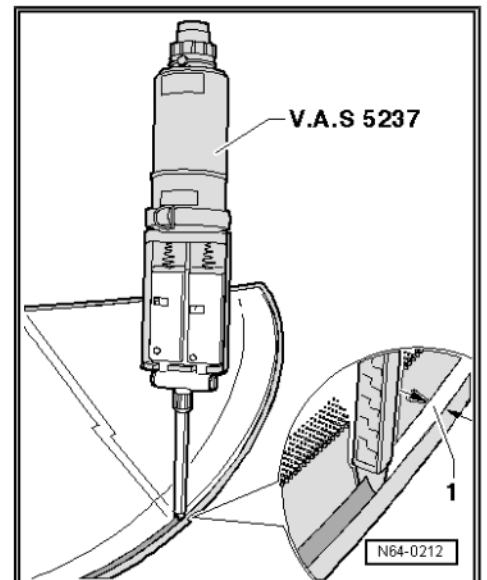


1.27 Assembly instructions



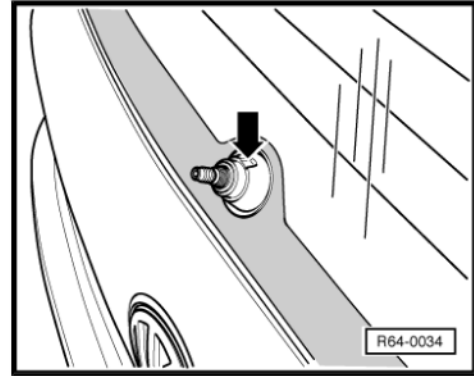
DANGER!

The glass must be placed within 10 minutes, otherwise its adhesion will be compromised.





- ◆ Place the glass on the body frame using two suction pad grippers - V.A.G 1344- , align and press inwards the spacer or the side glass packing (side glass).
- ◆ Apply the adhesive throughout the contour and at a straight angle in relation to the window.
- ◆ The beginning and end of the application of the PU adhesive DA 009 100 (see correspondence table ➔ [page 125](#)) must coincide with the lower centre of the glass.
- ◆ Windscreen clearance dimensions ➔ [page 126](#) .
- ◆ Side glass clearance dimensions (Fox) ➔ [page 128](#) .
- ◆ Side glass clearance dimensions (Spacefox / Suran) ➔ [page 131](#) .
- ◆ Clearance dimensions for rear glass (Fox) ➔ [page 134](#) .
- ◆ Clearance dimensions for rear glass (Spacefox / Suran) ➔ [page 136](#) .
- ◆ Fasten the windscreen during curing time with the windscreen shims -443 845 631 A-
- ◆ If there were originally installed warning tags (for example, for Airbag), they must be re-installed.
- ◆ When placing the sealing packing for the rear window wiper motor shaft, follow the assembly position (Fox and Spacefox / Suran). The marking -arrow- points upwards.
- ◆ The activator cannot be applied over the defogger fillets.
- ◆ There are markings on the right and left sides of the rear window for adhesive application.
- ◆ Fasten the rear window with adhesive tape during the curing time.
- ◆ If adhesive cord is applied out of specified dimensions, it may spread over defogging filaments. In this condition, the adhesive must be removed.



Note

- ◆ Check for water infiltration by hosing (without pressure) the external surface of the vehicle. Carefully observe the inside of the vehicle.
- ◆ Etch the VIS number on the replacement windows (Brazil only ➔ [page 126](#)), material to be used, ➔ Chemical Material Manual; Rep. gr. 00 ; Chemical Material Manual - List of authorized products .

1.28 Minimum adhesive drying time



WARNING

- ◆ When handling chemicals follow the safety instructions ➔ Chemical Products Manual; Rep. gr. 00
- ◆ Assignment of Chemical Materials ➔ Electronic Parts Catalogue "ETKA"



Note

- ◆ *In the event windows are to be replaced, certain requirements must be fulfilled in order to abide by the operational safety norms, even in the event of accidents.*
- ◆ *The vehicle may be delivered to the client 3 hours after repair. Inform the client of the precautions to be taken during the total adhesive drying time.*
- ◆ *The adhesive reacts with air humidity. The infiltration test accelerates the drying process of the adhesive.*

Type of glass	Vehicle	Window adhesive	Minimum drying time	Total drying time
Windscreen	With and without airbag	DH 009 100 or Kit for gluing windows	3 hours	72 hours
Side and rear windows				

During this time, the vehicle must remain on a flat surface and at room temperature (at least 59 °F).



DANGER!

The vehicle can only be delivered to the client after the minimum drying time because the safety requirements will only be fulfilled after this time.

1.29 Paint damage - repair



WARNING

- ◆ *When handling chemicals follow the safety instructions ⇒ Chemical Products Manual; Rep. gr. 00*
- ◆ *Assignment of Chemical Materials ⇒ Electronic Parts Catalogue "ETKA"*

Repaint following the procedures described in ⇒ Paint Manual - Paint repair in on steel plates and zinc-coated steel plates .

If damages to paint occur in areas which are not visible from outside, apply body primer - D 009 200 02-



Note

- ◆ *Minimum drying time of 10 minutes*
- ◆ *Only if the damage is located in the area covered by the component, otherwise the part must be repainted.*



1.30 Cleaning in case of resulting adhesive residues



WARNING

- ◆ *When handling chemicals follow the safety instructions ⇒ Chemical Products Manual; Rep. gr. 00*
- ◆ *Assignment of Chemical Materials ⇒ Electronic Parts Catalogue "ETKA"*

- We recommend, as cleaning product, the use of adhesive remover - D 002 000 A2- . Follow the safety rules during the application.



DANGER!

When cleaning from the vehicle cabin, do not press inside out a glass that has just been placed (cured adhesive).

- First, clean the painted surface with a dry cloth. Eliminate dirt remains with the adhesive remover - D 002 000 A2-
- Clean the plastic coating: Let the polyurethane adhesive dry (approximately 1 hour), then remove it.

1.31 Data stickers



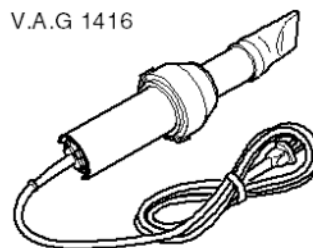
WARNING

- ◆ *When handling chemicals follow the safety instructions ⇒ Chemical Products Manual; Rep. gr. 00*
- ◆ *Assignment of Chemical Materials ⇒ Electronic Parts Catalogue "ETKA"*

Special tools and workshop equipment required

- ◆ Hot air blower - VAG 1416-

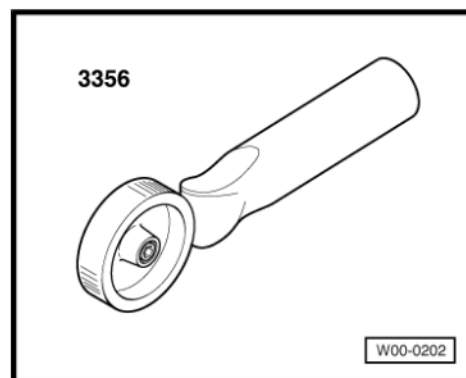
V.A.G 1416



W00-0004



◆ Pressure roll - 3356-



Note

The following procedure describes the removal and installation of the airbag sticker; this procedure applies also to the removal of all other windscreen stickers.

Remove



Note

Heat the data sticker using the hot air blower - VAG 1416- prior to removal

- Detach the data sticker using a plastic spatula.
- Clean the windscreen with the adhesive remover - D 002 000 A2- .

Install

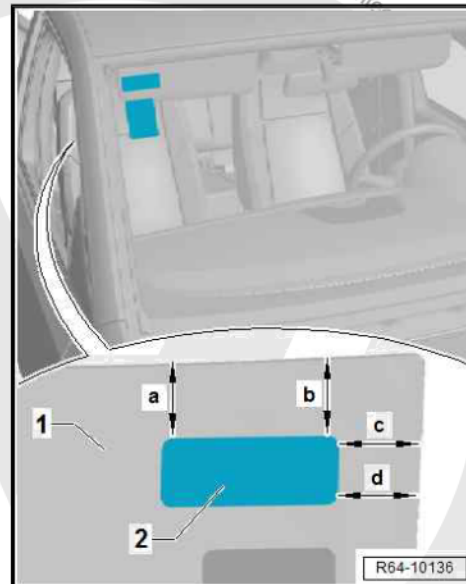
- Align the data sticker -2- as per the respective dimensions and attach the sticker -2- to the windscreen -1-. Use pressure roll - 3356-

a = 50 mm

b = 53 mm

c = 47 mm

d = 46 mm





2 Door window glass

2.1 Front door window glass (2-door) - assembly overview

1 - Door window glass

- ☐ Label request for engraving the VIS number on windows (Brazil only)
⇒ [page 126](#)

- ☐ Remove and install
⇒ [page 147](#)

2 - Door window external trim

- ☐ fitted onto flange

3 - Door groove

- ☐ fitted onto flange

4 - Door window internal trim

- ☐ fitted onto flange

5 - Door

6 - Window drive mechanism

- ☐ Remove and install
⇒ [page 151](#)

7 - Power window drive mechanism

- ☐ Remove and install
⇒ [page 151](#)

8 - Washer

- ☐ 5 units

9 - Pop rivet

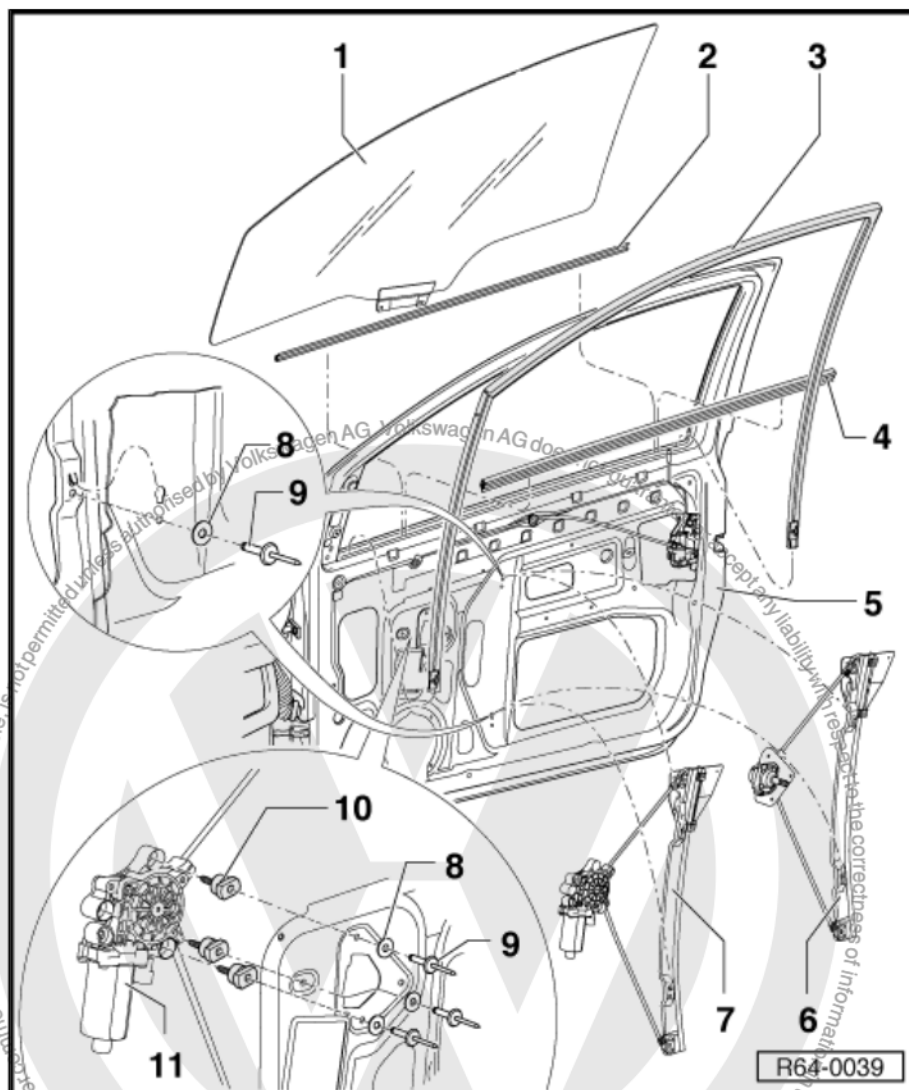
- ☐ 5 units
- ☐ Replace
- ☐ Drill the rivet for disassembly

10 - Pad

- ☐ Torque: 3.5 Nm
- ☐ 3 units
- ☐ replace whenever mechanism 6- or -7- is removed.

11 - Window drive motor

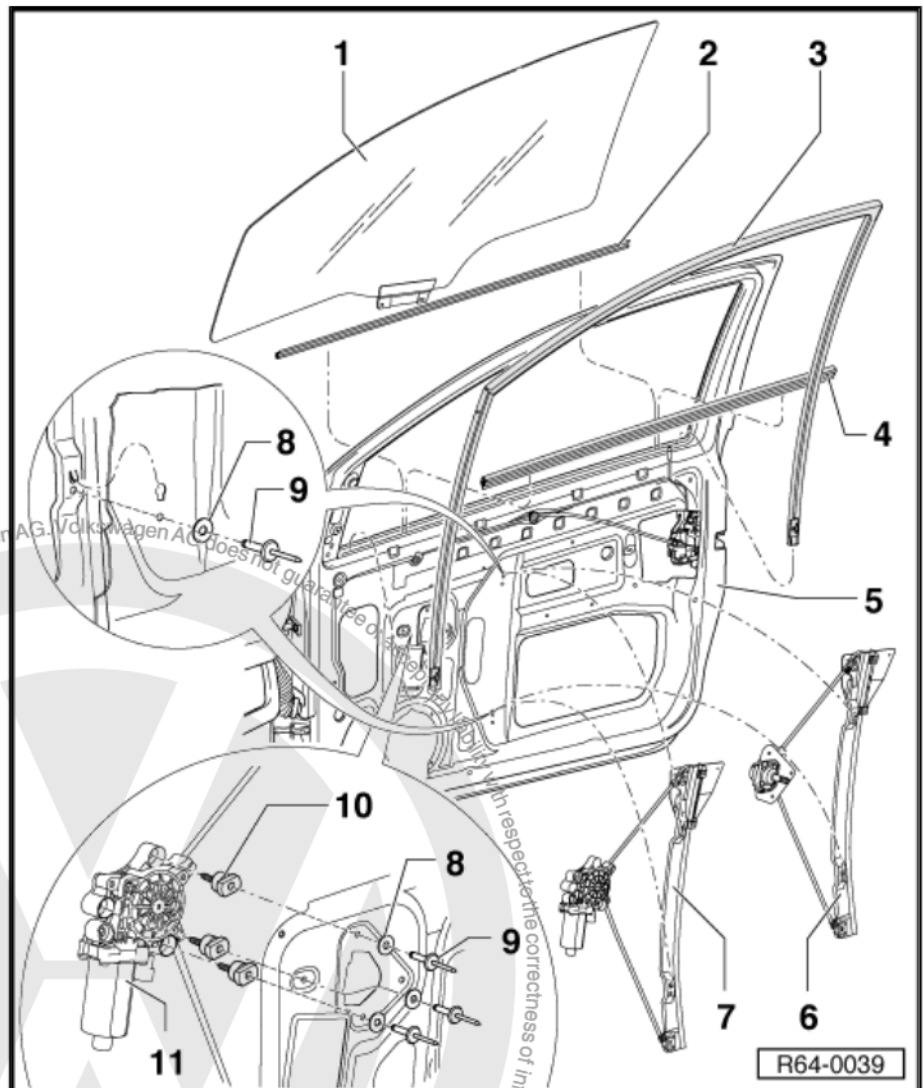
- ☐ Remove and install ⇒ [page 151](#)





2.2 Front door window glass (4-door) - Assembly overview

- 1 - Door window glass
 - ☐ Remove and install
⇒ [page 147](#) .
- 2 - External trim
 - ☐ Remove and install
⇒ [page 153](#)
- 3 - Chute
 - ☐ Remove and install
⇒ [page 153](#)
- 4 - Internal trim
 - ☐ Remove and install
⇒ [page 153](#)
- 5 - Door
- 6 - Manual window drive mechanism
 - ☐ Remove and install
⇒ [page 152](#) .
- 7 - Power window drive mechanism
 - ☐ Remove and install
⇒ [page 151](#) .
- 8 - Washer
 - ☐ 5 units
- 9 - Pop Rivet
 - ☐ 5 units
 - ☐ Drill rivet for disassembly
- 10 - Pad
 - ☐ Torque: 3.5 Nm
 - ☐ 3 units
 - ☐ replace whenever mechanism -6- or -7- is removed.
- 11 - Window drive motor
 - ☐ Remove and install ⇒ [page 151](#)



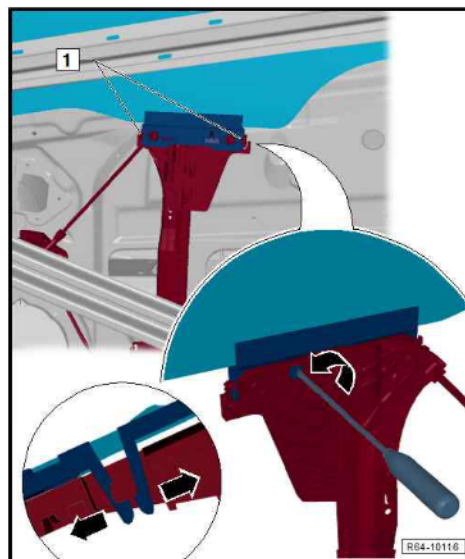
2.3 Front door window glass - remove and install

Removal:

- Remove the front door lining ⇒ General body repairs, interior;
Rep. gr. 70 ; Lining / insulation
- Partially remove the sealing membrane.



- Lower door window glass until the support is accessible on the window activation mechanism.
- Unlock locks -1- manually.
- Use a screwdriver to unlock the glass support in the glass activation mechanism support. Turn the screwdriver to unlock.
- Disengage the activation mechanism glass support.

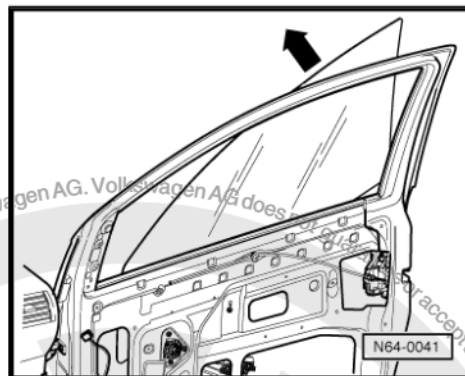


- Lift the door window glass from behind, turn outside the door forward and, towards -arrow-, forwards.

Installation:

Installation is performed in the reverse sequence; in this case, observe the following:

- After assembling the door window glass, you must check the operation of the window drive mechanism.



2.4 Convenience system window drive mechanism (automatic window closing and opening mechanism) with force limiter (anti-crushing function)

The front window drive mechanisms are additionally equipped with the automatic window closing and opening mechanism for the vehicles with convenience system.

The automatic window opening and closing switches for the front window are located at the driver's door control. The switches for the passenger's door are equipped with a two-level function.

If the respective switch is pushed or pulled up to the first level, the front window opens or closes manually.

If the switch is completely pushed or pulled up to the second level, the window will open or close automatically.

Additionally, on the passenger's door there is an additional switch for the passenger's door window.

All power drive mechanisms are equipped with a force limiter (anti-crushing device). The window closing is automatically interrupted when an obstacle blocks the closing route.

However, that is not valid for window closing determined from the outside, with the ignition key. In this case, there is no force limitation.



2.4.1 Operation of the window drive mechanism with the ignition turned on

Opening:

Switch on the driver's door

- Press the switch up to the first level. The window glass is opened while the switch is pressed down or when the final position is reached.
- Briefly press the switch down to the second level. The window glass opens automatically (automatic lowering).
- If the switch is operated again, the window glass will stop immediately.

Switch on the passenger's door

- Press the lower switch surface. The window glass is opened while the switch is pressed down or when the final position is reached.

Closing:

Switch on the driver's door

- Pull switch up to the first level. The window glass is closed while the switch is pulled or when the final position is reached.
- Briefly pull the switch up to the second level. The window glass closes automatically (automatic closing).
- If the switch is operated again, the window glass will stop immediately.

Switch on the passenger's door

- Press the upper switch surface. The window glass is closed while the switch is pressed down or when the final position is reached.

2.4.2 Operation of the window drive mechanism with the ignition turned off

The window drive mechanisms can still be operated for approx. 10 minutes after the ignition is turned off, while the driver's or the passenger's door is not opened.

For window closing, there is no automatic closing function available.

If the driver's or the passenger's door window cannot be closed due to mobility problems or the presence of an obstacle to the closing (force limiter), the window glass immediately opens.

In this case, the window glass can only be closed again if the ignition is turned on.

The window glasses can still be opened or closed from the outside in vehicles with central locking. For this purpose, the key only needs to be pressed in the closing or opening position.



2.4.3 Actuation of automatic window closing and opening mechanism



Note

After disconnecting / connecting the battery of the vehicle or after some actuations of the force limiter function, the automatic door window closing and opening mechanism will be disabled.

For enabling this function, we should follow the procedure below:

- Press the key until fully closing the window glass and keep it pressed for a few seconds. Repeat this operation for the other door window glass keys that have this function disabled.

By pressing or pulling a button until the first level, the window opens or closes while the button is being activated.

The door window glass opens automatically (automatic opening) or closes automatically (automatic closing) whenever pressing or pulling the key briefly.

The glass will stop at the current position if the key is pressed while the door window glass opens or closes.

After turning the ignition off, there is no one-touch opening and closing function, even when the key is still inserted in the ignition cylinder

2.4.4 Force limiter function (anti-crushing device)

- Condition: Automatic window glass closing and opening function disabled.
- Ignition key inserted in the ignition cylinder and ignition on.
- Close the door window glass with the window drive switch (automatic closing).



Note

The door window will stop and the glass will move backward some centimetres if the door window does not close due to an obstacle (force limiter was activated).

- Ignition key inserted in the door lock cylinder or the remote control is actuated through the outer portion of the vehicle.
- Turn the door lock cylinder with the ignition key in the closing direction or actuating the remote control in the locking direction.



Note

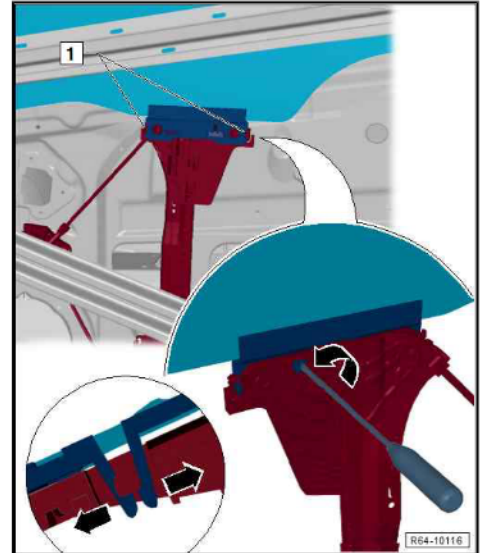
When the force limiter is activated, the door window will stop on closing and move backward a few centimetres when hitting an obstacle. The alarm horn emits three sound warnings "Beeps" and the "Led" of the alarm system in the door locking pin frame remains steadily lit up.



2.5 Electrical window drive mechanism - remove and install

Removal:

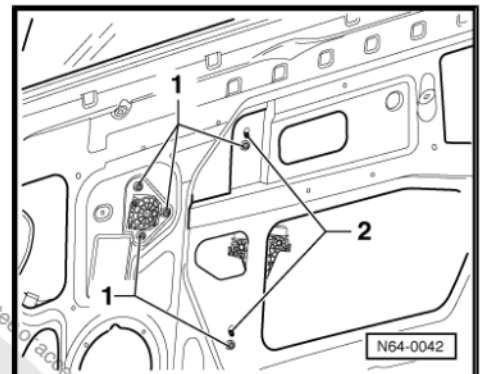
- Remove the front door lining ⇒ General body repairs, interior; Rep. gr. 70 ; Lining / insulation
- Partially remove the sealing membrane.
- Lower door window glass until the support is accessible on the window activation mechanism.
- Unlock locks -1- manually.
- Use a screwdriver to unlock the glass support in the glass activation mechanism support. Turn the screwdriver to unlock.
- Disengage the activation mechanism glass support.



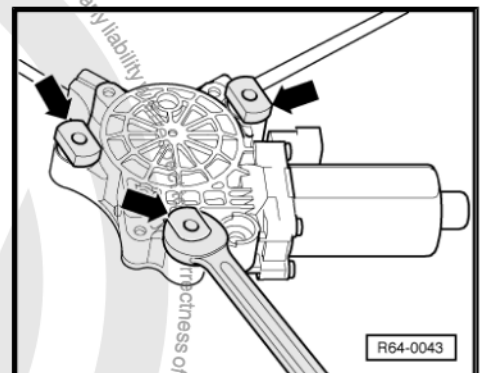
- Drill pop rivets -1-, lift the window activation mechanism from the couplings -2- and remove downward out through the assembly opening.

Installation:

Install is performed in the reverse sequence, observing the following:



- Replace mountings -arrows-. Fasten new mounting to a Torque of: 3.5 Nm.
- Fasten glass activation mechanism to door with pop rivets; do not forget washers in this case.
- After assembling the door window glass, you must check the operation of the window drive mechanism.



2.6 Window drive motor - remove and install

Removal:

- Remove window activation mechanism ⇒ [page 151](#).



- Unscrew fastening screws -arrows-.
- Remove motor -1- from glass activation -2-.

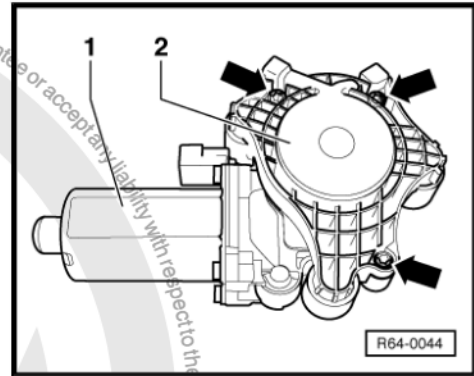
Installation:

Installation is performed in the reverse sequence; in this case, observe the following:

- Tighten fastening screws with:

Torque: 3.5 Nm

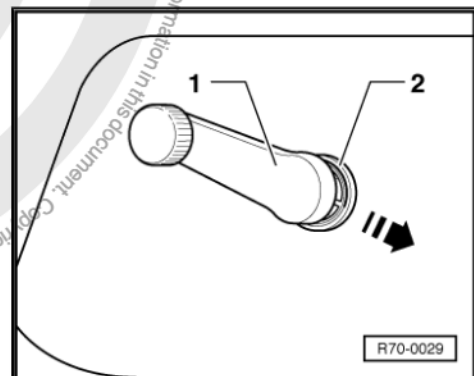
- Before installing the window drive mechanism, you must check its operation.



2.7 Front door window winder - remove and install

Removal:

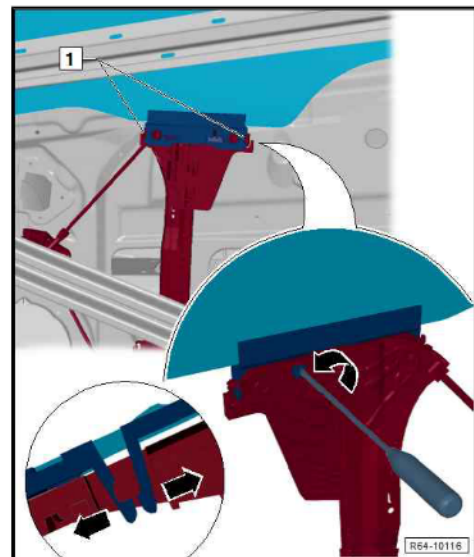
- With the door window fully closed, move the crank spacer in the indicated direction.
- Disengage the crank and remove it.
- Remove the door lining ⇒ General body repairs, interior; Rep. gr. 70 ; Lining / Insulation .
- Partially remove the sealing membrane.



- Lower door window glass until the support is accessible on the window activation mechanism.
- Unlock locks -1- manually.
- Use a screwdriver to unlock the glass support in the glass activation mechanism support. Turn the screwdriver to unlock.
- Disengage the activation mechanism glass support.
- Push the door's window glass up, and lock it.
- Drill pop rivets, lift the window activation mechanism from the couplings and remove the set downward out through the door opening.

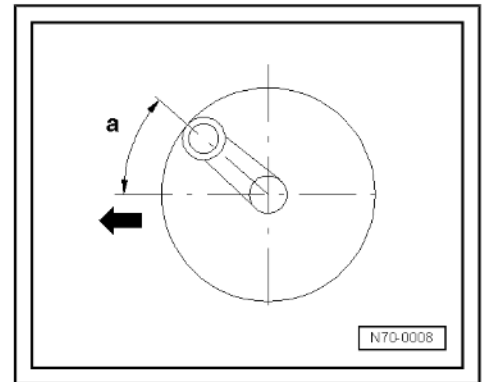
Installation:

- Installation is performed in the reverse sequence to the removal, considering the following:
- Fasten door glass activation mechanism with pop rivets and do not forget washers.





- Position the crank at 45° in the indicated direction and fit the spacer.
- After assembling the door window glass, check the operation of the window activation mechanism. Figure -arrow- points wheeling direction.



2.8 Front door window channel - remove and install

Removal:

- Remove the door window ⇒ [page 147](#) .
- Carefully disengage and remove the channel.

Installation:

- Installation is performed in the reverse sequence to the removal.

2.9 Front door window internal trim - remove and install

Removal:

- Remove the door lining ⇒ General body repairs, interior; Rep. gr. 70 ; Lining / insulation .
- Remove the trim by disengaging it from the door.

Installation:

- Installation is performed in the reverse sequence to the removal.

2.10 Front door window external trim - replace

Removal:

- Disengage trim and remove it.

Installation:

- Installation is performed in the reverse sequence to the removal.

2.11 Rear door window glass - assembly overview



1 - Door window glass

- ☐ Label request for engraving the VIS number on windows (Brazil only)
⇒ [page 126](#)
- ☐ Remove and install
⇒ [page 155](#).

2 - Door window fixed glass

- ☐ Remove ⇒ [page 159](#).

3 - Rear chute

4 - Insert

5 - Rear guide rail

- ☐ Remove and install
⇒ [page 158](#)

6 - Bolt

- ☐ Torque: 5.5 Nm

7 - Plug

8 - Door

9 - Window drive mechanism

- ☐ Remove and install
⇒ [page 156](#).

10 - Power window drive mechanism

- ☐ Remove and install
⇒ [page 156](#).

11 - Pop Rivet

- ☐ 5 units
- ☐ Drill the rivet for disassembly.

12 - Washer

- ☐ 5 units

13 - Pad

- ☐ Torque: 3.5 Nm
- ☐ 3 units
- ☐ Replace whenever mechanism -9 -or -10- is removed.

14 - Cap

15 - Window drive motor

- ☐ Remove and install ⇒ [page 156](#)

16 - Internal trim

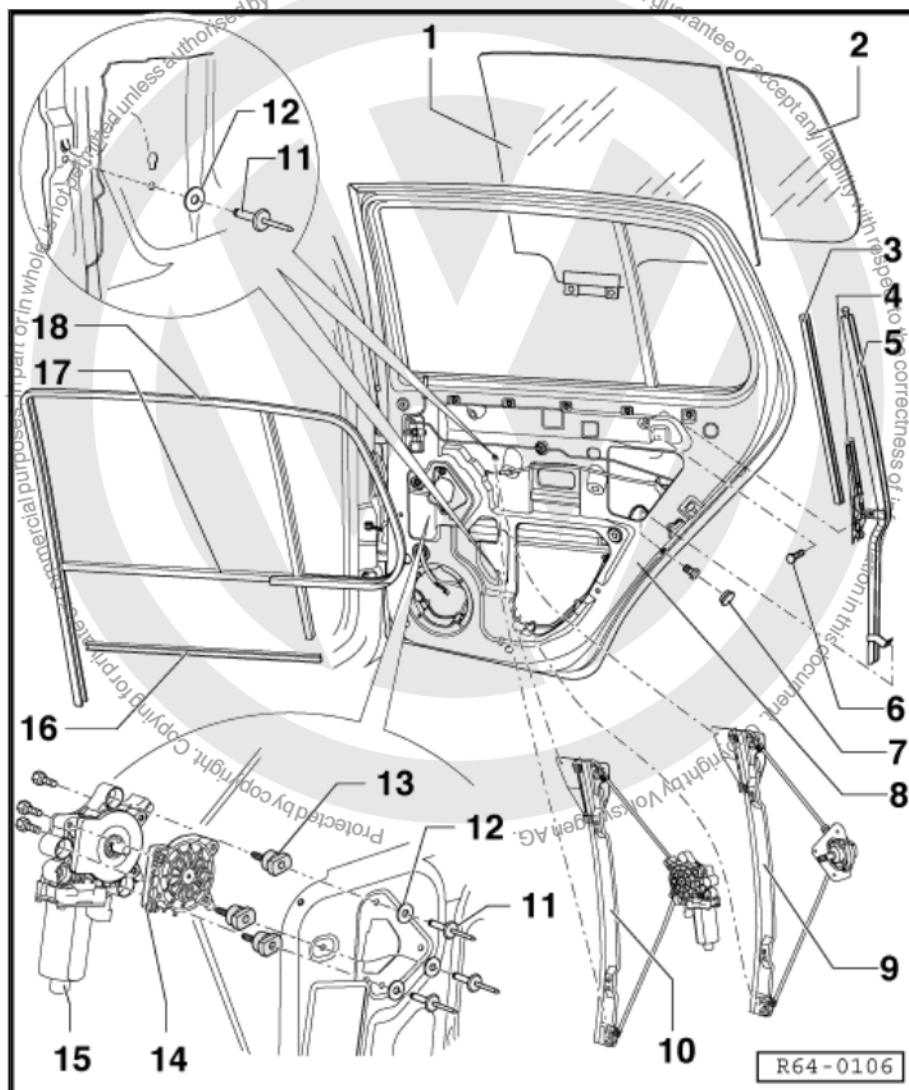
- ☐ Remove and install ⇒ [page 158](#)

17 - External trim

- ☐ Remove and install ⇒ [page 159](#)

18 - Chute

- ☐ Remove and install ⇒ [page 158](#)

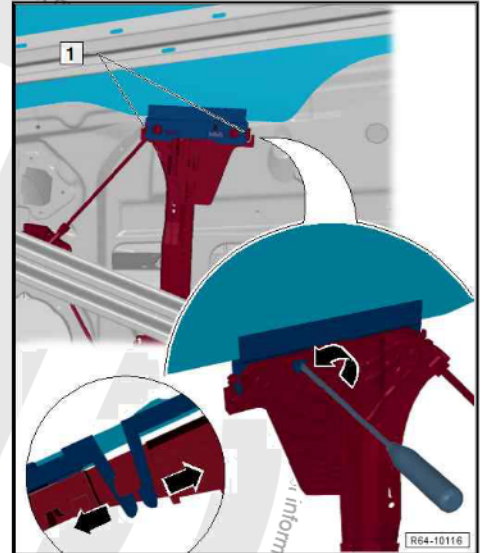




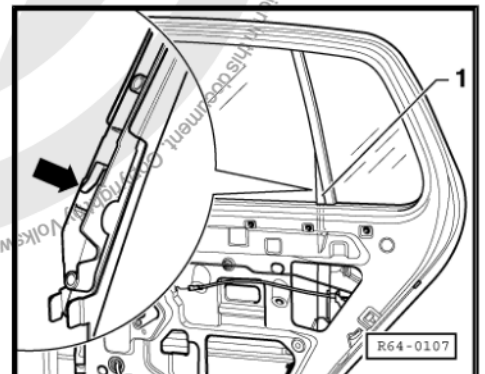
2.12 Rear door window glass - remove and install

Removal:

- Remove the door lining ⇒ General body repairs, interior; Rep. gr. 70 ; Lining / insulation .
- Partially remove the sealing membrane.
- Lower door window glass until the support is accessible on the window activation mechanism.
- Unlock locks -1- manually.
- Use a screwdriver to unlock the glass support in the glass activation mechanism support. Turn the screwdriver to unlock.
- Disengage the activation mechanism glass support.
- Remove upper screw from rear guide rail.
- Remove internal packing from door.
- Unlock groove upward in rear guide rail section.



- Move thread -1- by pushing it upward until its lock -arrow- is released.
- Remove thread.
- Then, lift door window glass carefully removing it from the door internal side.



Installation:

- Installation is performed in the reverse sequence to the removal.

2.13 Rear door window power activation mechanism - remove and install

Removal:

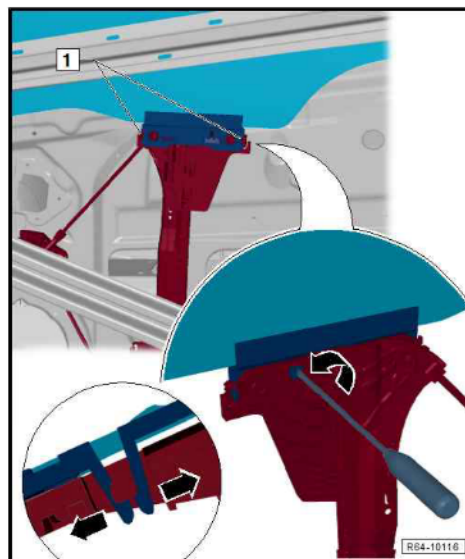
- Remove the door lining ⇒ General body repairs, interior; Rep. gr. 70 ; Lining / insulation .
- Partially remove the sealing membrane.



- Lower door window glass until the support is accessible on the window activation mechanism.
- Unlock locks -1- manually.
- Use a screwdriver to unlock the glass support in the glass activation mechanism support. Turn the screwdriver to unlock.
- Disengage the activation mechanism glass support.
- Push the door's window glass up and immobilize it.
- Drill "pop" rivets, lift the window activation mechanism from the couplings, and remove the set downward out through the door opening.

Installation:

- Installation is performed in the reverse sequence to the removal, considering the following:
- Fasten door glass activation mechanism with "pop" rivets and do not forget washers.



2.14 Rear door window drive motor - remove and install

Removal:

- Remove window power activation mechanism ⇒ [page 155](#).
- Unscrew fastening screws -arrows-.
- Remove engine -1- from glass activation mechanism -2-.

Installation:

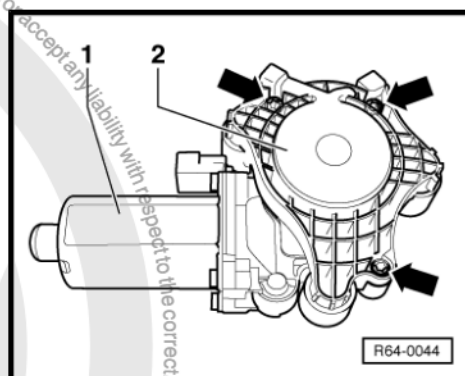
Install is performed in the reverse sequence, observing the following:

- Tighten the fastening bolts to a Torque of: 3.5 Nm.



Note

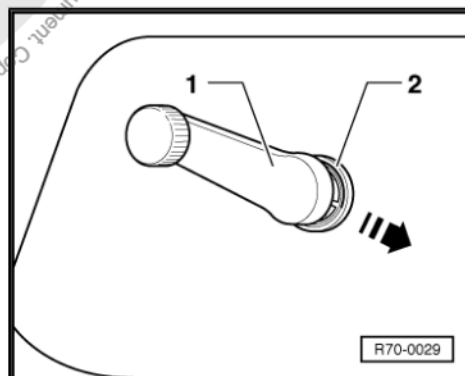
Before installing the window power activation mechanism, check its operation.



2.15 Rear door window drive mechanism - remove and install

Removal:

- With the door window fully closed, move the crank spacer in the indicated direction.
- Disengage the crank and remove it.
- Remove the door lining ⇒ General body repairs, interior, Rep. gr. 70 ; Lining / insulation .
- Partially remove the sealing membrane.

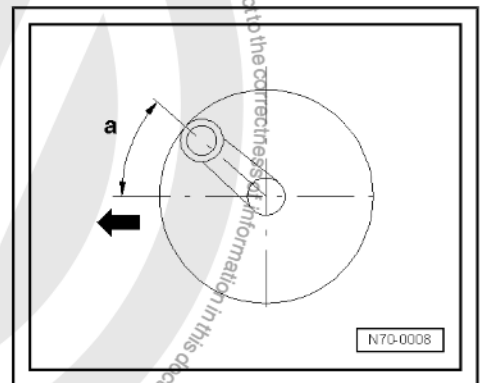
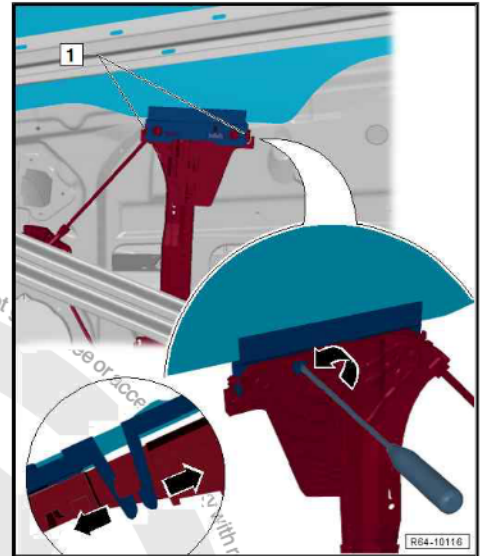




- Lower door window glass until the support is accessible on the window activation mechanism.
- Unlock locks -1- manually.
- Use a screwdriver to unlock the glass support in the glass activation mechanism support. Turn the screwdriver to unlock.
- Disengage the activation mechanism glass support.
- Push the door's window glass up, and lock it.
- Drill pop rivets, lift the window activation mechanism from the couplings and remove the set downward out through the door opening.

Installation:

- Installation is performed in the reverse sequence to the removal, considering the following:
- Fasten door glass activation mechanism with "pop" rivets and do not forget washers.
- Position the crank at 45° in the indicated direction and fit the spacer.
- After assembling the door window glass, check the operation of the window activation mechanism. Figure -arrow- points wheeling direction.



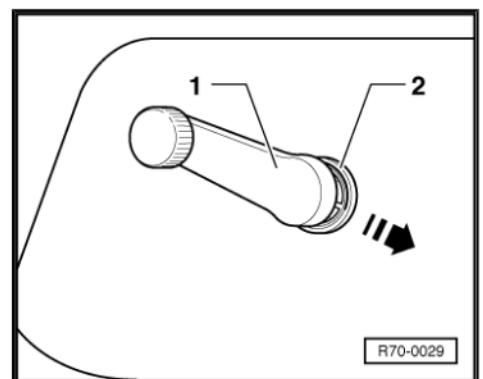
2.16 Door window activation crank - remove and install

Removal:

- With the door window fully closed, move the crank spacer in the indicated direction.
- Disengage the crank and remove it.

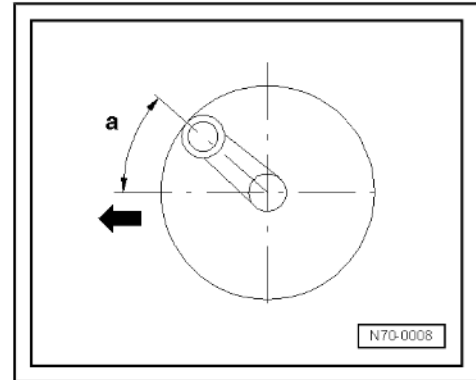
Installation:

- Installation is performed in the reverse sequence to the removal, considering the following:





- Position the crank at 45° in the indicated direction and fit the spacer.
- After assembling the door window glass, check the operation of the window activation mechanism. Figure -arrow- points wheeling direction.



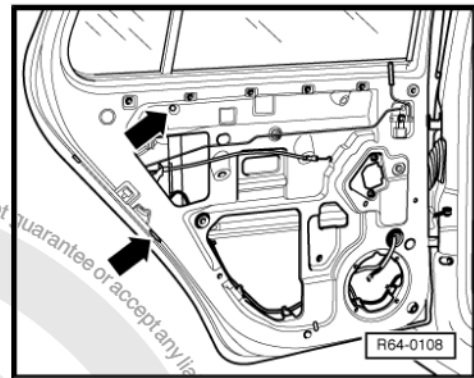
2.17 Rear door glass rear guide rail - remove and install

Removal:

- Remove rear door window glass ⇒ [page 155](#) .
- Remove screws from rear guide rail "arrows".
- Move rear door glass upper chute away along with the fixed glass.
- Remove rear guide rail, disengaging it from the door.

Installation:

- Installation is performed in the reverse sequence to the removal.



2.18 Rear door window channel - remove and install

Removal:

- Remove the door window ⇒ [page 155](#) .
- Remove rear guide rail from rear door ⇒ [page 158](#)
- Carefully disengage and remove groove along with rear door fixed glass.

Installation:

- Installation is performed in the reverse sequence to the removal.

2.19 Rear door window internal trim - remove and install

Removal:

- Remove the door lining ⇒ General body repairs, interior; Rep. gr. 70 ; Lining / insulation .
- Remove the trim by disengaging it from the door.

Installation:

- Installation is performed in the reverse sequence to the removal.



2.20 Rear door window external trim - replace

Removal:

- Disengage trim and remove it.

Installation:

- Installation is performed in the reverse sequence to the removal.

2.21 Rear door fixed glass - replace

Removal:

- Remove rear guide rail from rear door ⇒ [page 158](#)
- Disengage rear door window glass along with chute.

Installation:

- Fit rear door window glass along with chute.
- Install rear door rear guide rail ⇒ [page 158](#) .





66 – Exterior equipment

1 Materials used and operational care required

1.1 Auxiliary materials for Brazilian market



WARNING

- ◆ *When handling chemicals follow the safety instructions ⇒ Chemical Products Manual; Rep. gr. 00*
- ◆ *Assignment of Chemical Materials ⇒ Electronic Parts Catalogue "ETKA"*

- ◆ Glass adhesion kit ⇒ Chemicals Manual; Rep. gr. 00 ; Chemicals Manual - List of authorized products - ¹⁾, ²⁾, ³⁾
- ◆ Adhesive remover D 002 000 A2¹
- ◆ Activator for PP surfaces D 181 655 R1 ¹, ⁴
- ◆ Cutting wire 357 853 999.A
- ◆ Silicone remover LSE 020 100 A3 ¹
- ◆ Cleaning solution D 009 401 04 ¹

17) Observe the procedural indications in accordance with the manufacturer's prescriptions for packaging disposal

18) Exclusive option for the Brazilian market. The Kit includes (U-400 HV) 310 ml cartridge, primer (primer 5404 A), activator / glass cleaner (primer 5500).

19) Heat up according to manufacturer instructions Cartridge heater - VAG 1939-

20) Used only in polypropylene components with no applied base layer. Reapply in the application area in the event the layer has been damaged.

21) Follow the minimum drying time ⇒ [page 162](#) .

1.2 Auxiliary materials for export market



WARNING

- ◆ *When handling chemicals follow the safety instructions ⇒ Chemical Products Manual; Rep. gr. 00*
- ◆ *Assignment of Chemical Materials ⇒ Electronic Parts Catalogue "ETKA"*

- ◆ 1K Glass adhesive DH 009 100 - 300 ml or DH 009 100 03 - 110 ml ¹, ³, ⁴
- ◆ Activator for PP surfaces D 181 655 R1 ¹, ², ⁴
- ◆ Glass/painting primer D 009 200 02 ⁴
- ◆ Cutting wire 357 853 999.A



- ◆ Silicone remover LSE 020 100 A3 ¹
- ◆ Adhesive remover D 002 000 A2¹
- ◆ Cleaning solution D 009 401 04 ¹
- ◆ Primer applicator D 009 500 25

22) Observe the procedural indications in accordance with the manufacturer's prescriptions for packaging disposal.

23) Used only in polypropylene components with no applied base layer. Reapply in the application area in the event the layer has been damaged.

24) Heat up according to manufacturer instructions Cartridge heater - VAG 1939-

25) Follow the minimum drying time ➔ [page 162](#) .

1.3 Matching table

WARNING

- ◆ *When handling chemicals follow the safety instructions ➔ Chemical Products Manual; Rep. gr. 00*
- ◆ *Assignment of Chemical Materials ➔ Electronic Parts Catalogue "ETKA"*

Note

To help understanding, please find below a comparison table for materials used in the Brazilian and export markets

Product	Brazilian Market	Export Market
PU 1K Adhesive	U-400 HV	DH 009 100 - 300 ml or DH 009 100 03 - 110 ml
Body primer	Primer 5404 A	D 009 200 02

1.4 Paint damage - repair

WARNING

- ◆ *When handling chemicals follow the safety instructions ➔ Chemical Products Manual; Rep. gr. 00*
- ◆ *Assignment of Chemical Materials ➔ Electronic Parts Catalogue "ETKA"*

Repaint ➔ Paint Manual - Paint repair in on steel plates and zinc-coated steel plates .

For paint damages in non visible areas the following repair method is recommended:

- Paint twice (humid on humid) with paint primer - D 009 200 02- . Use the primer applicator - D 009 500 25- - Minimum drying time for the primer is 10 minutes.



1.5 Cleaning in case of dirt residues resulting from handling of polyurethane adhesive (PU)



WARNING

- ◆ *When handling chemicals follow the safety instructions ⇒ Chemical Products Manual; Rep. gr. 00*
- ◆ *Assignment of Chemical Materials ⇒ Electronic Parts Catalogue "ETKA"*

- Apply the adhesive remover - D 002 000 A2- onto the affected surface. Follow the safety rules during the application.
- First, clean the painted surface with a dry cloth. Eliminate dirt remains with the adhesive remover - D 002 000 A2- .

1.6 Minimum adhesive drying time

Minimum adhesive drying time is the period from the installation of the component until the delivery of the vehicle to the customer. This time is 3 hours. During this period, the vehicle must remain on a level surface and at room temperature (minimum 59° F).



WARNING

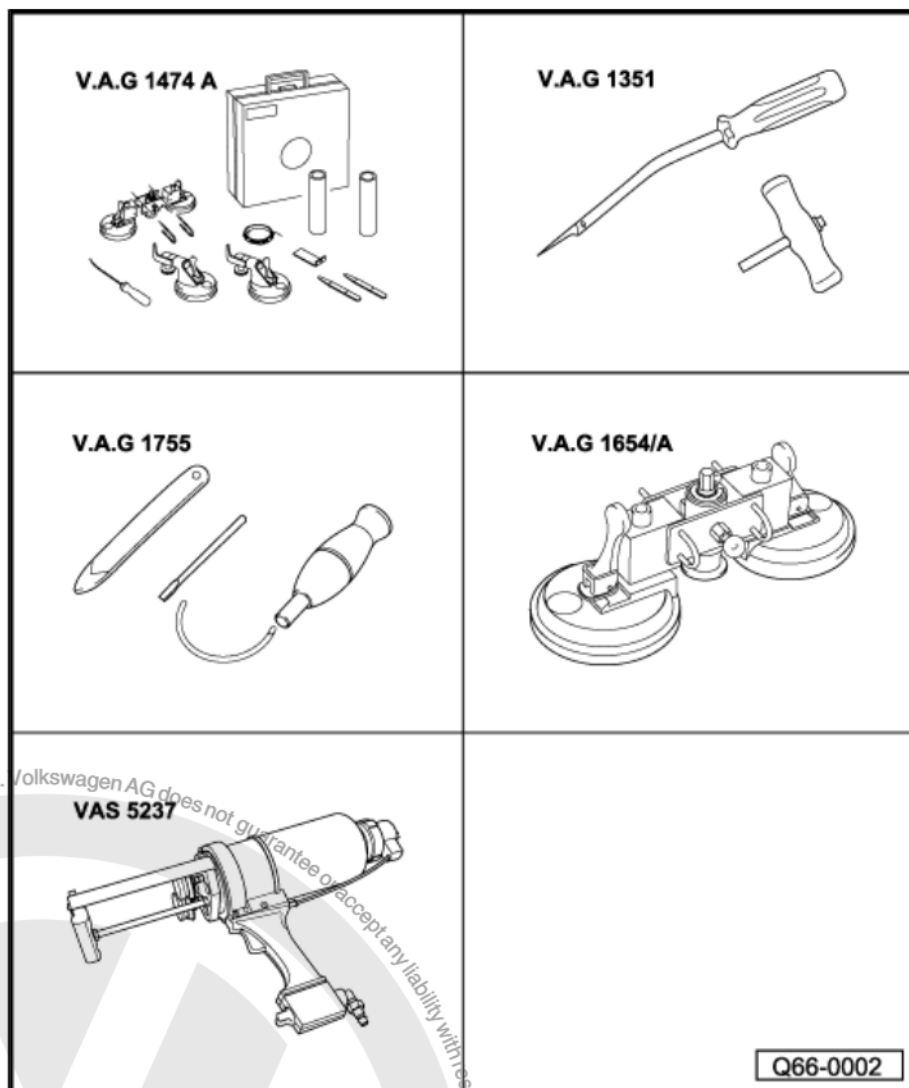
The vehicle can only be released after the minimum curing period has elapsed.



2 Spoiler

2.1 Roof spoiler (Fox) - Assembly overview

Special tools and workshop equipment required



- ◆ Anchoring tool - VAG 1351-
- ◆ Glass removal tools - VAG 1474B- or Device with ratchet - VAG 1654A-
- ◆ Glass removal kit - VAG 1755-
- ◆ Pneumatic adhesive applicator - VAS 5237-



2.1.1 Materials



WARNING

- ◆ *When handling chemicals follow the safety instructions ⇒ Chemical Products Manual; Rep. gr. 00*
- ◆ *Assignment of Chemical Materials ⇒ Electronic Parts Catalogue "ETKA"*

- ◆ 2K- adhesive -DA 004 600 A2- ^{1, 2}
- ◆ Mixing tube -D 002 001-
- ◆ Activator -D 181 801 A1-
- ◆ Primer -D 181 711 A1-
- ◆ Cleaning solution -D 009 401 04-
- ◆ Primer Applicator -D 009 500 25-
- ◆ Adhesive remover -D 002 000 A2-
- ◆ Cutting wire -357 853 999 A-

26) Respect the minimum drying time. ⇒ [page 168](#)

27) The Adhesive pneumatic applicator -VAS 5237- must be used with these materials.

2.1.2 Spoiler - Assembly overview



1 - Spoiler

- ☐ Remove ⇒ [page 165](#)
- ☐ Install ⇒ [page 166](#)
- ☐ Installation instructions ⇒ [page 168](#)
- ☐ Material: ABS + PC

2 - Primer application area on the body

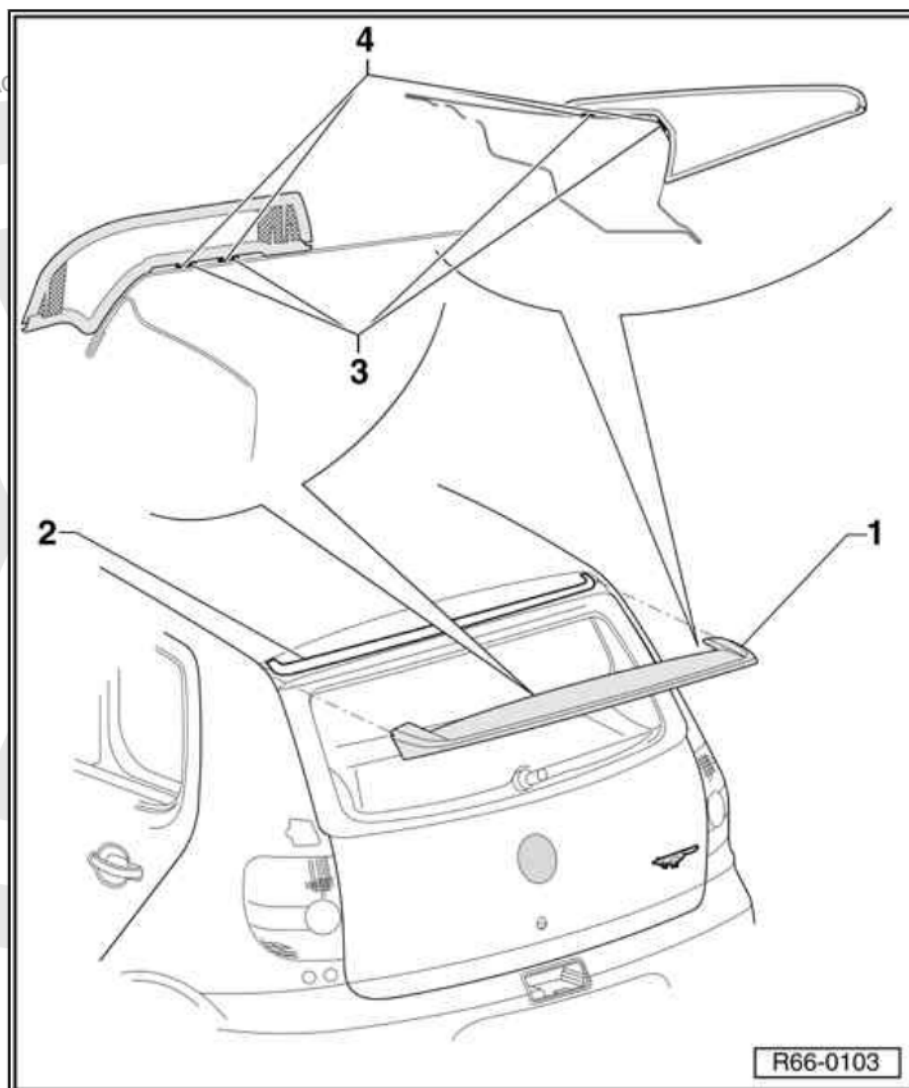
- ☐ Preparation ⇒ [page 167](#)

3 - Adhesive

- ☐ Polyol + PUR pre-polymer

4 - Primer /adhesive application area on spoiler

- ☐ Preparation ⇒ [page 167](#)



2.1.3 Spoiler - remove



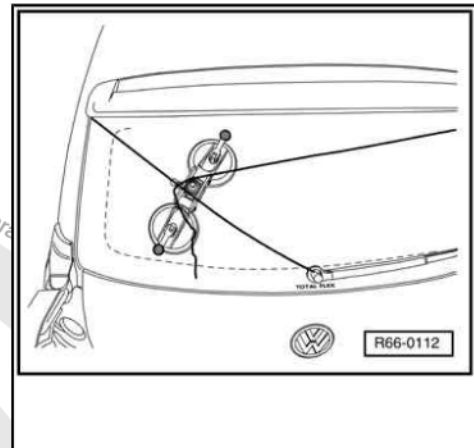
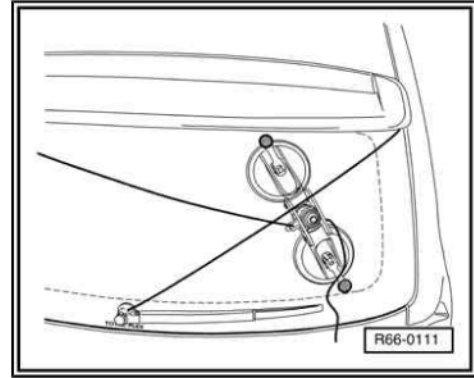
WARNING

Do not use any metallic cutting wire for removing the spoiler; otherwise, the paintwork may be damaged.

- Clean the spoiler support area so there is no damage to the paintwork when removing.
- Protect the rear door and the roof painting around the spoiler.



- Position the device with ratchet - VAG 1654A- as shown in the illustration and fasten one of the cutting wire ends. The other edge must be fixed on rear glass cleaner wiper blade shaft.
 - When cutting, introduce the cutting wire between the spoiler and the rear lid with a plastic wedge.
 - Keep traction on cutting wire until approximately half the vehicle.
-
- Reposition device with ratchet - VAG 1654A- as shown in the picture, and begin cutting once again from other side.
 - Remove the spoiler.



2.1.4

Spoiler - install



1 - Spoiler

- ☐ Material: ABS + PC
- ☐ Installation instructions
⇒ [page 168](#)

2 - Primer application area on the body

- ☐ Preparing the body for application of adhesive
⇒ [page 167](#)
- ☐ Repairing damage to paintwork ⇒ [page 169](#)



Note

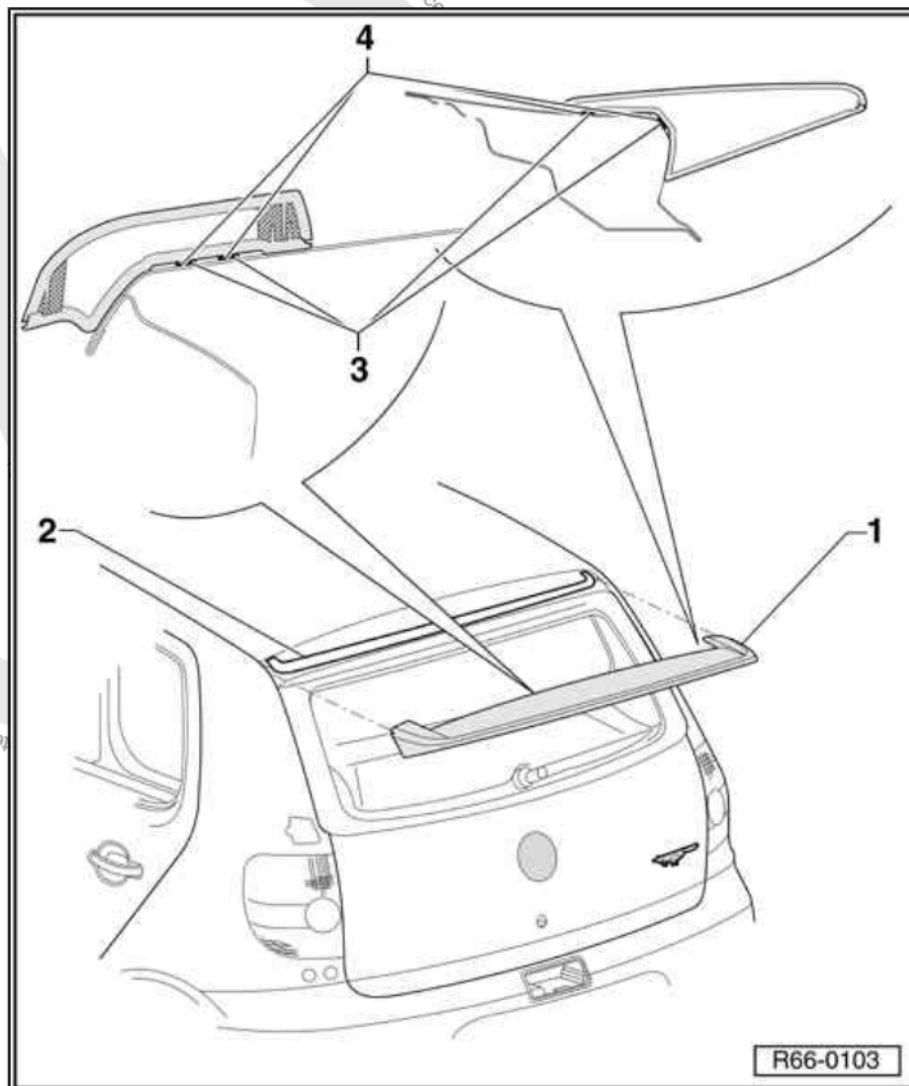
Minimum drying time -

3 - Adhesive

- ☐ Polyol + PUR pre-polymer
- ☐ Minimum adhesive curing time ⇒ [page 168](#)

4 - Primer /adhesive application area on spoiler

- ☐ Adhesive cord must be:
 - ◆ 3-mm large
 - ◆ 5-mm height
- ☐ Cleaning the areas affected by the adhesive
⇒ [page 169](#)



2.1.5 Preparing the body for application of adhesive



WARNING

- ◆ When handling chemicals follow the safety instructions ⇒ Chemical Products Manual; Rep. gr. 00
- ◆ Assignment of Chemical Materials ⇒ Electronic Parts Catalogue "ETKA"



- Thoroughly clean the spoiler installation region.



Note

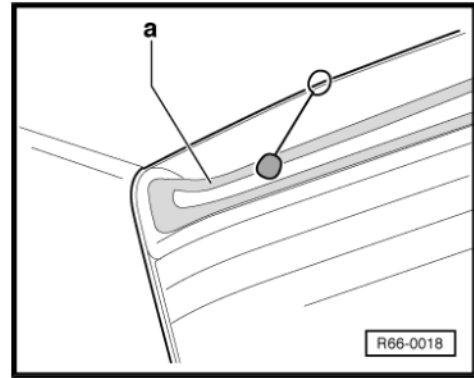
Old adhesive layer works as anchoring for the new cord. Adhesive application areas should be thoroughly free from dirt or oiliness.

If spoiler is not installed immediately after cutting old adhesive layer -a-, then it shall be activated with activator - D 181 801 A1- .



WARNING

The activator must not contact the painted surface. Otherwise, the painting will be damaged.



- ◆ If rear lid is replaced or repainted, apply primer for body - D 009 200 02- using the applicator - D 009 500 25-

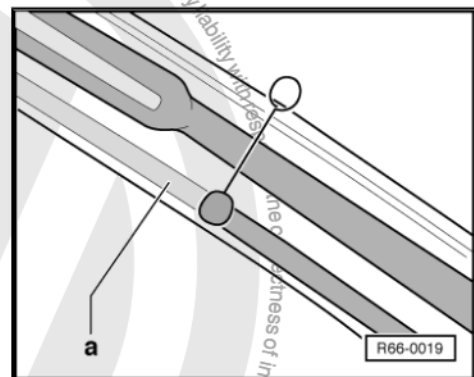
2.1.6 Installation instructions



WARNING

- ◆ *When handling chemicals follow the safety instructions → Chemical Products Manual; Rep. gr. 00*
- ◆ *Assignment of Chemical Materials → Electronic Parts Catalogue "ETKA"*

- Prepare body for application of adhesive ⇒ [page 167](#)
- Remove the adhesive remains with the adhesive remover - D 002 000 A2- .
- Moisten a cloth with the silicone remover - LSE 020 100 A3- .
- Clean thoroughly the adhesive application area with cloth soaked with solvent.
- Apply Primer homogeneously with the applicator - D 009 500 25- .
- ◆ The drying time is of approximately 10 minutes.



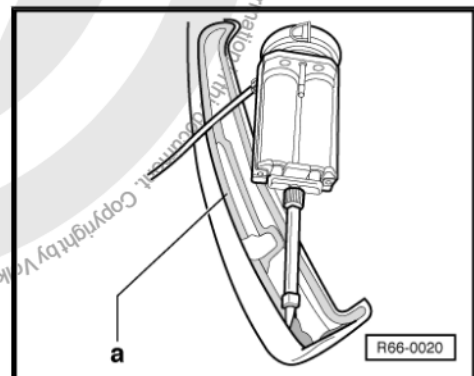
- Apply adhesive under primer application -a- area on spoiler.



WARNING

The spoiler must be installed within 10 minutes after applying the primer. Otherwise, the adherence will be impaired.

During the drying period, fasten the spoiler with masking tape.



2.1.7 Minimum adhesive drying time

Minimum adhesive curing time is the period from the spoiler installation to the delivery of the vehicle to the customer. This time



is 3 hours. During this period, the vehicle must remain on a level surface and at room temperature (minimum 59° F).



Note

The vehicle can only be released after the minimum curing period has elapsed.

2.1.8 Repairing damage to paintwork



WARNING

- ◆ *When handling chemicals follow the safety instructions ⇒ Chemical Products Manual; Rep. gr. 00*
- ◆ *Assignment of Chemical Materials ⇒ Electronic Parts Catalogue "ETKA"*

Repaint following the procedures described in ⇒ Paint Manual - Paint repair in on steel plates and zinc-coated steel plates .

If damages to paint occur in areas which are not visible from outside, apply body primer - D 009 200 02-



Note

Minimum drying time is 10 minutes.

2.1.9 Cleaning the areas affected by the adhesive



WARNING

- ◆ *When handling chemicals follow the safety instructions ⇒ Chemical Products Manual; Rep. gr. 00*
- ◆ *Assignment of Chemical Materials ⇒ Electronic Parts Catalogue "ETKA"*

- The painted surfaces should be cleaned using a clean and dry cloth. Clean the other areas with the adhesive remover - D 002 000 A2- .



Note

The adhesive remover - D 002 000 A2- is the cleaning agent. All safety rules must be followed.

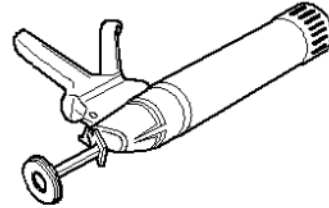
2.2 Spoiler (Spacefox / Suran) - remove and install

Special tools and workshop equipment required



- ♦ Manual pressure gun - VAG 1628- or Pneumatic Adhesive applicator for glued glasses - EQ 7434-

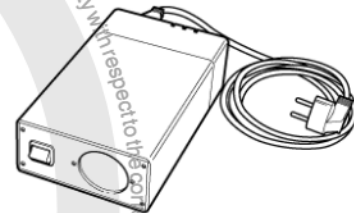
V.A.G 1628



W00-0536

- ♦ Cartridge heater - VAG 1939- or Cartridge heater - VAG 1939A-

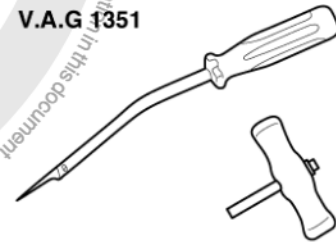
V.A.G 1939



W00-0537

- ♦ Traction cable - VAG 1351/1-

V.A.G 1351



W00-0531

2.3 Assembly overview



1 - Adhesive bead

- ☐ The adhesive cord must be 9^{+1} mm wide and 6^{+1} mm high.

2 - Spoiler

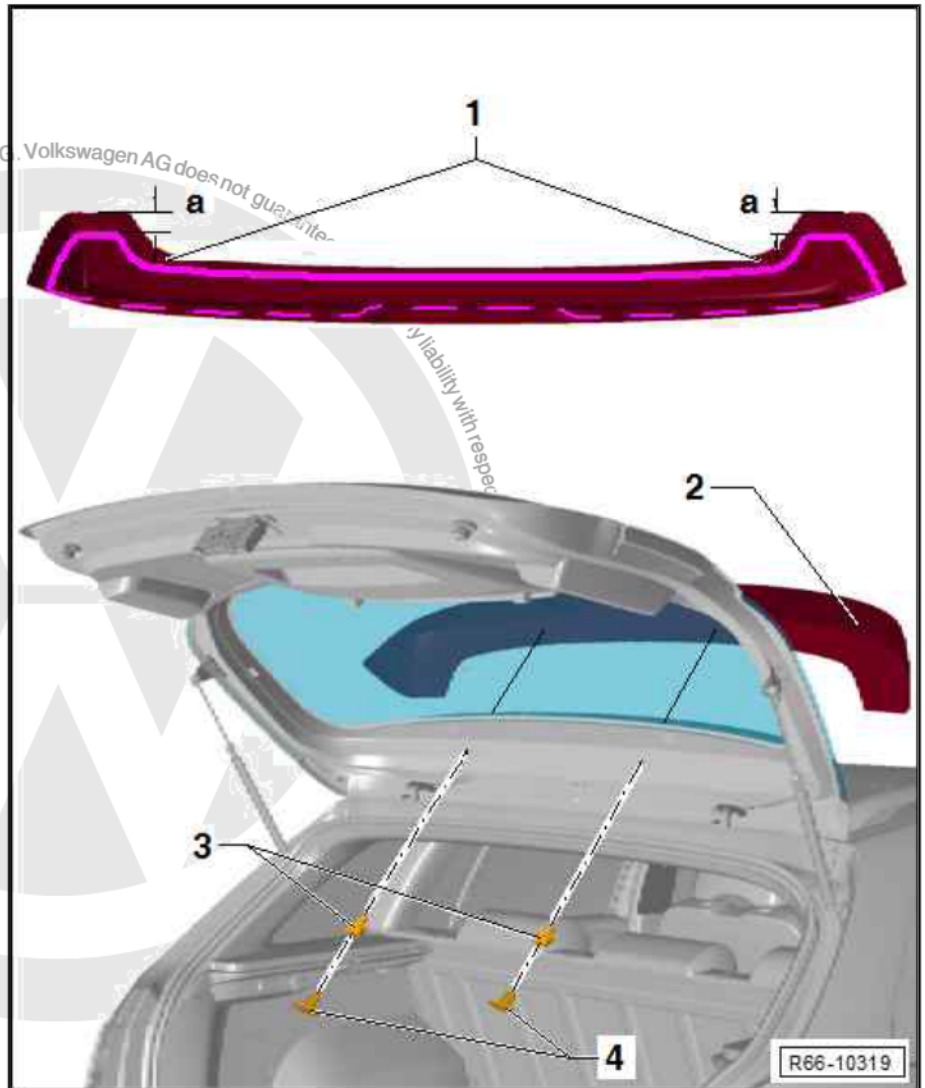
- ☐ Remove [⇒ page 171](#)
- ☐ Install [⇒ page 173](#)

3 - Bolt

- ☐ 2 units
- ☐ Torque: 3 Nm

4 - Plug

- ☐ 2 units



2.4 Observations for the execution of the removal and installation of the spoiler

Auxiliary materials Brazilian market [⇒ page 160](#)

Auxiliary materials for the export market [⇒ page 160](#)

Matching table [⇒ page 161](#)

Minimum adhesive curing time [⇒ page 161](#)

Cleaning in case of dirt residues resulting from handling of polyurethane adhesive (PU) [⇒ page 162](#)

Paintwork damage - repair [⇒ page 161](#)

2.5 Remove



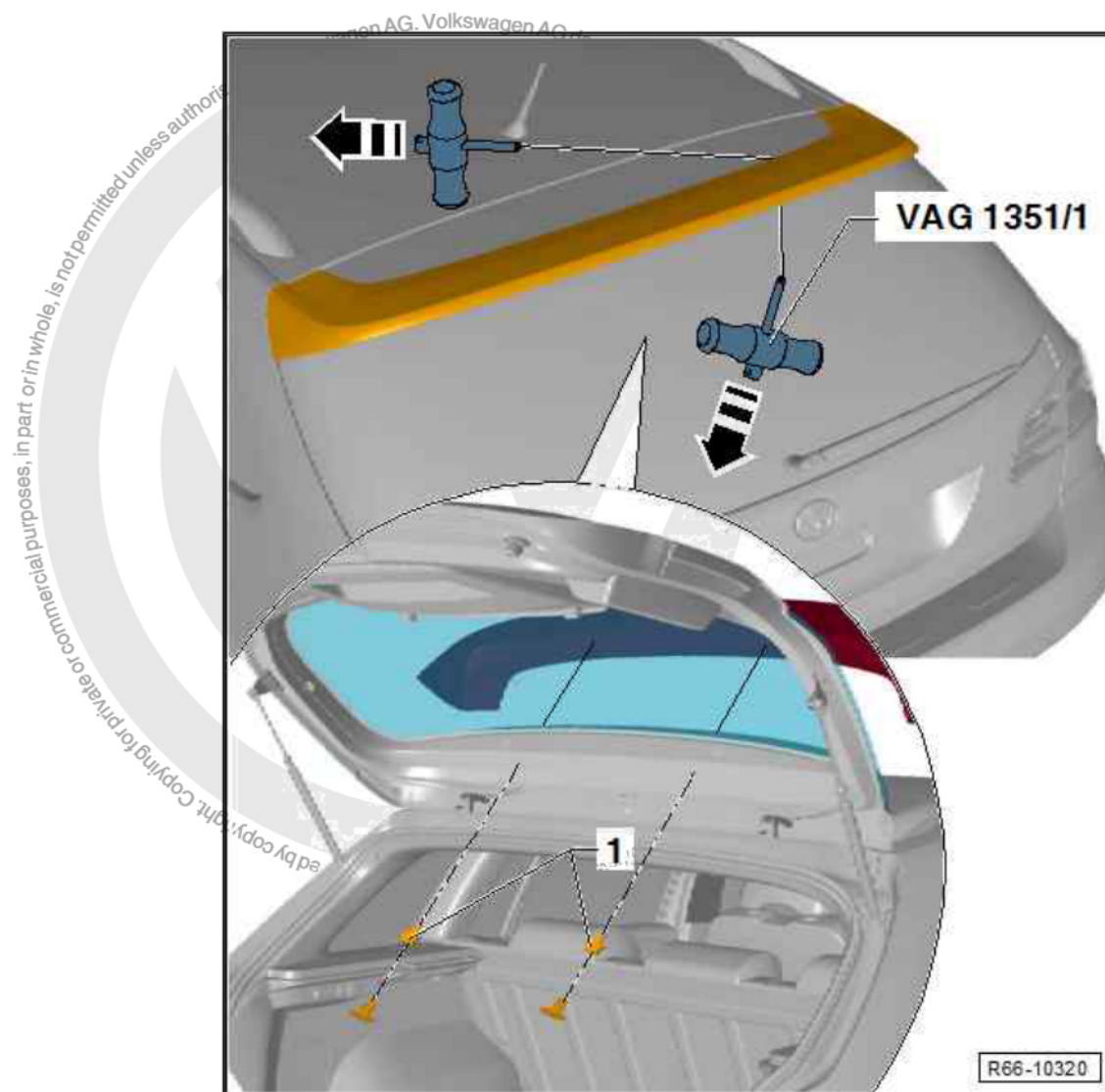
WARNING

Do not use any metallic cutting wire for removing the spoiler; otherwise, the paintwork may be damaged.

- Clean the spoiler support area so there is no damage to the paintwork when removing.



- Protect the paintwork of the rear lid and the roof around the spoiler with adhesive tape.



- Remove plugs and bolts -1- fastening the spoiler.
- Fasten the cutting wire - 357 853 999.A- to two traction cables - VAG 1351/1- .
- Position the cutting wire between the spoiler and the door and, after that, traction the cutting wire through the traction cables - VAG 1351/1- .
- Remove the spoiler.



2.6 Install

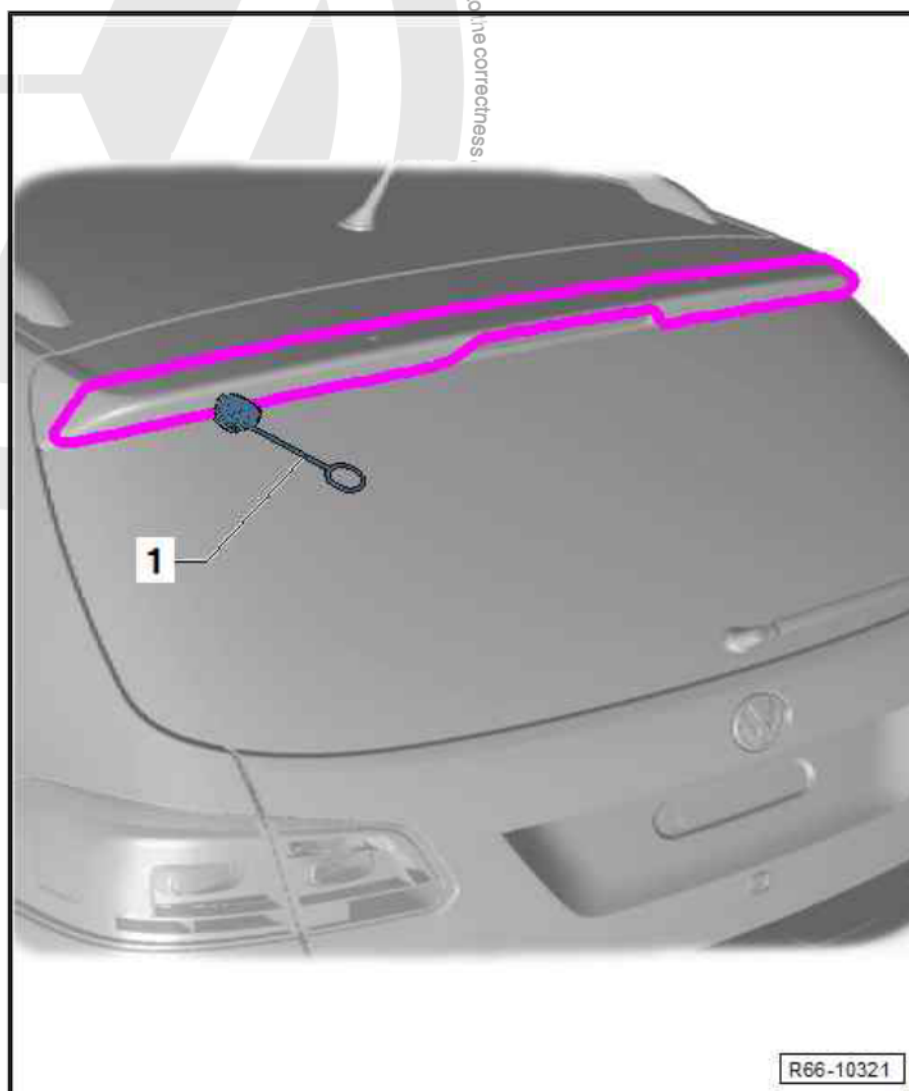
2.6.1 Preparing the body for application of adhesive



WARNING

- ◆ *When handling chemicals follow the safety instructions ➔ Chemical Products Manual; Rep. gr. 00*
- ◆ *Assignment of Chemical Materials ➔ Electronic Parts Catalogue "ETKA"*

- Cut the adhesive layer on the rear lid and on the spoiler, reducing it to -1 mm-high, approximately.
- Remove the paintwork protection masking tape.
- Carefully clean the support area of the spoiler -1- with adhesive remover - D 002 000 A2- and then apply cleaning solution - D 009 401 04-
- Repair any damage to the paintwork ➔ [page 161](#) .





Note

- ◆ The residual adhesive bead serves as the adherence base for the new bead. The gluing areas should be thoroughly free from dirt or oiliness.
- ◆ For replacement lids/ apply primer - D 009 200 02- with applicator - D 009 500 25- -1- in the application area of the PU adhesive. The drying time of the primer is 10 minutes.
- ◆ See "Observations for operational execution" ⇒ [page 171](#) .

2.6.2 Installation instructions



WARNING

- ◆ When handling chemicals follow the safety instructions ⇒ Chemical Products Manual; Rep. gr. 00
- ◆ Assignment of Chemical Materials ⇒ Electronic Parts Catalogue "ETKA"

The surfaces where the Primer is to be applied on should be free from residues/dirt.

- Remove the adhesive remains with the adhesive remover - D 002 000 A2- .
- Moisten a cloth with the silicone remover - LSE 020 100 A3- . Clean thoroughly the adhesive application area with cloth.



Note

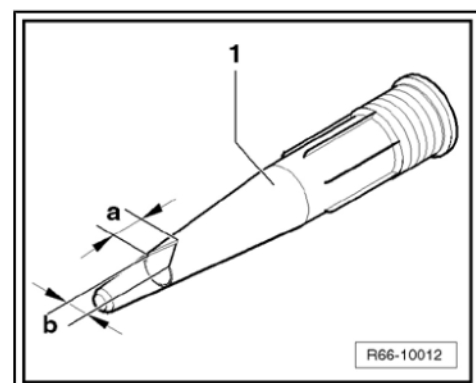
- ◆ For replacement spoilers, apply primer - D 009 200 02- with an applicator - D 009 500 25- in the application area of the PU adhesive. The drying time of the primer is 10 minutes.
- ◆ See "Observations for operational execution" ⇒ [page 171](#) .

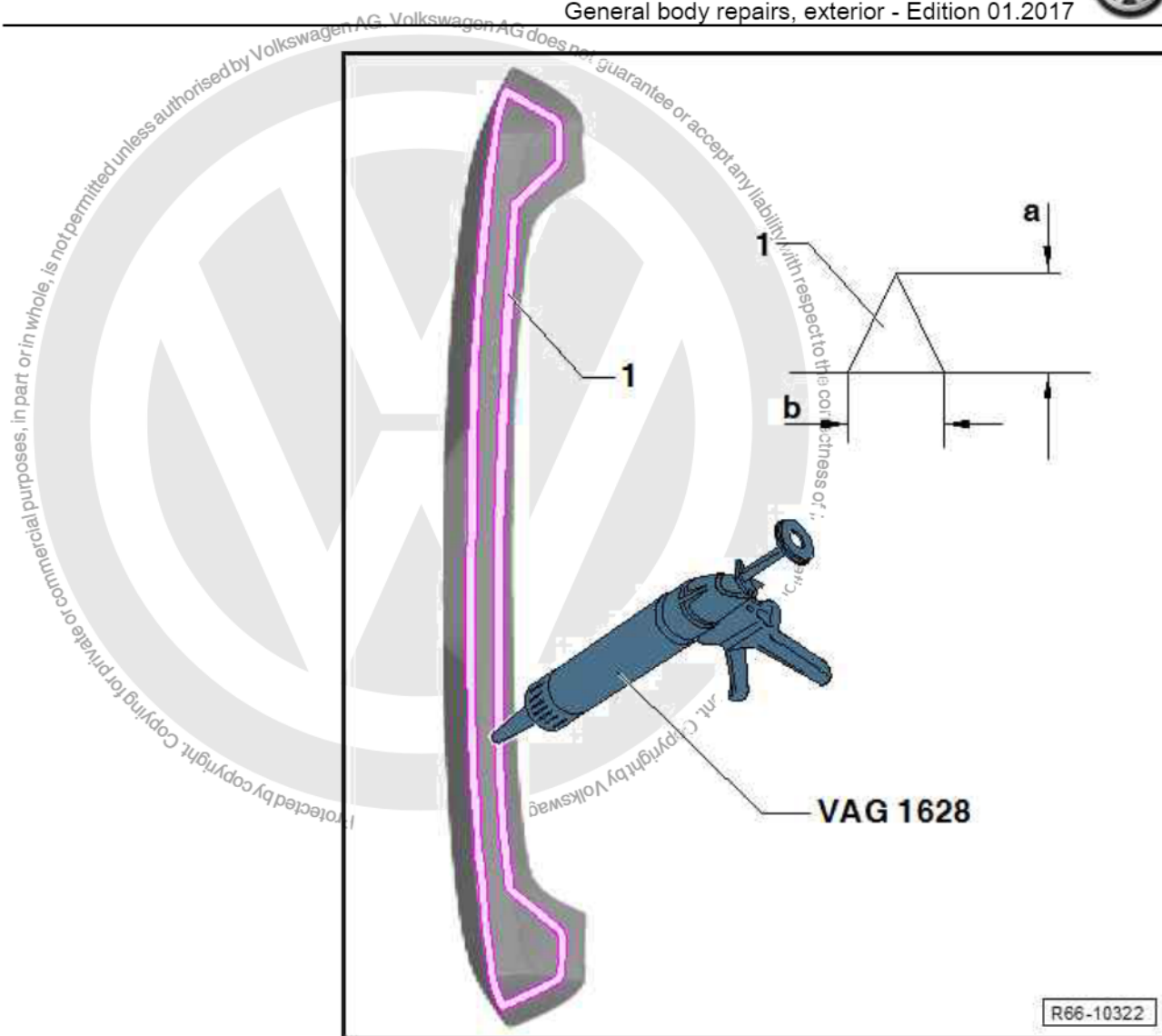
- Cut adhesive dispenser -1- nozzle.

a = 9 ⁺¹mm

b = 6 ⁺¹mm

- Heat the DH 009 100 - 300 ml or DH 009 100 03 - 110 ml adhesive cartridge, with cartridge heater - VAG 1939- or cartridge heater - VAG 1939A- .





- Apply the adhesive with the application of primer with a manual pressure pistol - VAG 1628- or pneumatic adhesive applicator for glued windows - EQ 7434- .



WARNING

Pay attention to the sizes of the adhesive thread.

The roof spoiler must be installed, at the most, 10 minutes after applying the adhesive. Otherwise, the adherence will be impaired.

- ◆ The openings must be at least 1 mm.
- ◆ During the curing period, fasten the spoiler with masking tape.
- Position the roof spoiler with the help of an assistant.



Note

- ◆ *Cleaning in case of dirt residues resulting from handling of polyurethane adhesive (PU) ⇒ [page 162](#)*
- ◆ *Await the minimum drying time ⇒ [page 162](#) .*





3 Roof Rack

3.1 Roof rack (Crossfox) - Assembly overview

1 - Roof rack

- ☐ Remove and install
⇒ [page 177](#)

2 - Rack fastening support

- ☐ Replace ⇒ [page 179](#)

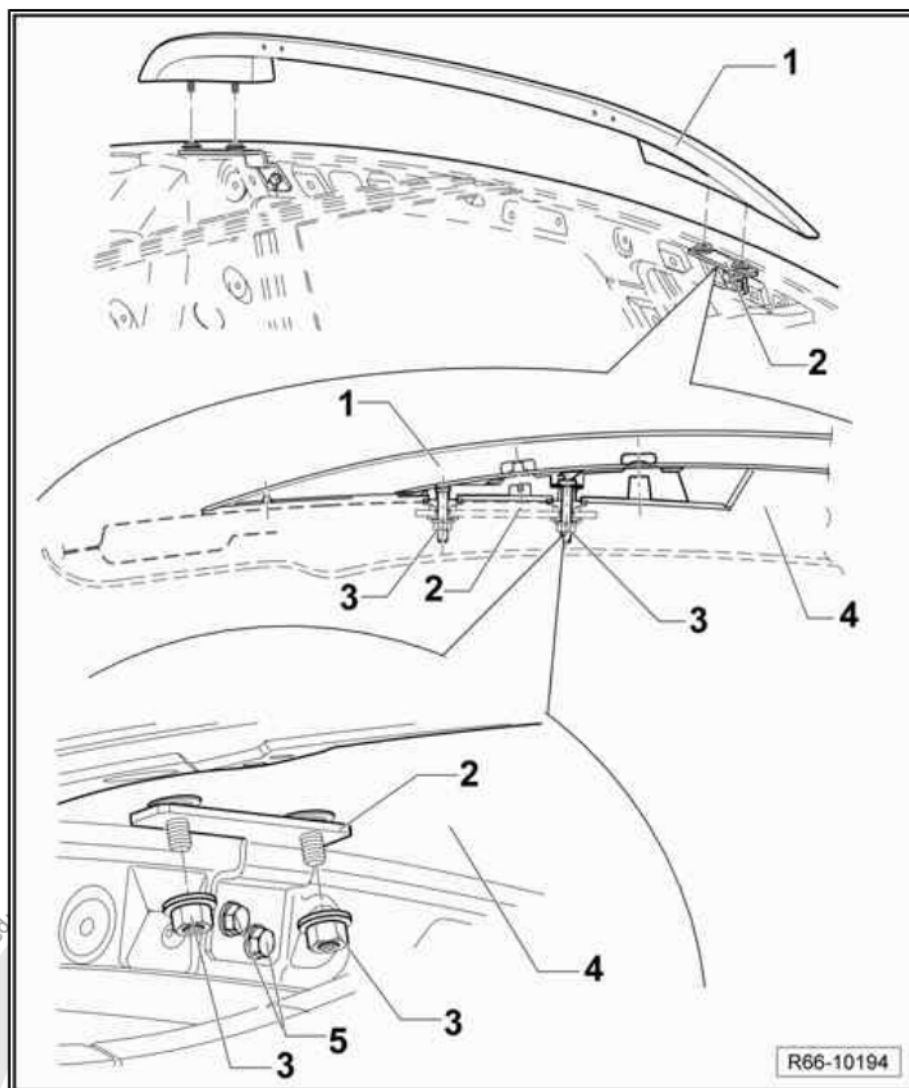
3 - Nut

- ☐ Torque: 8 Nm

4 - Roof

5 - Bolt

- ☐ Torque: 20 Nm

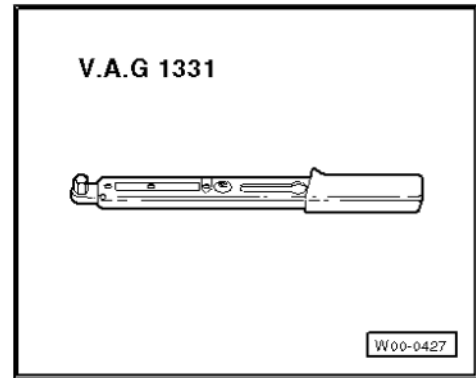


3.2 Roof rack (Crossfox) - remove and install

Special tools and workshop equipment required



- ◆ Torque wrench - 5 to 50Nm (1/2" drive) - VAG 1331-

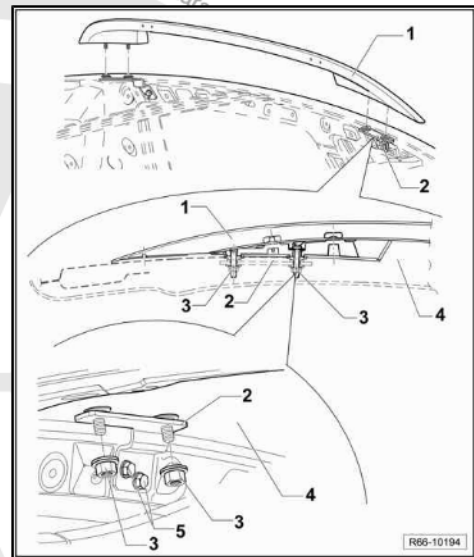


Removal:

- Remove roof lining ⇒ General body repairs, interior; Rep. gr. 70 ; Lining / insulation .
- Remove nuts -3- .
- Carefully remove the rack -1-.

Installation:

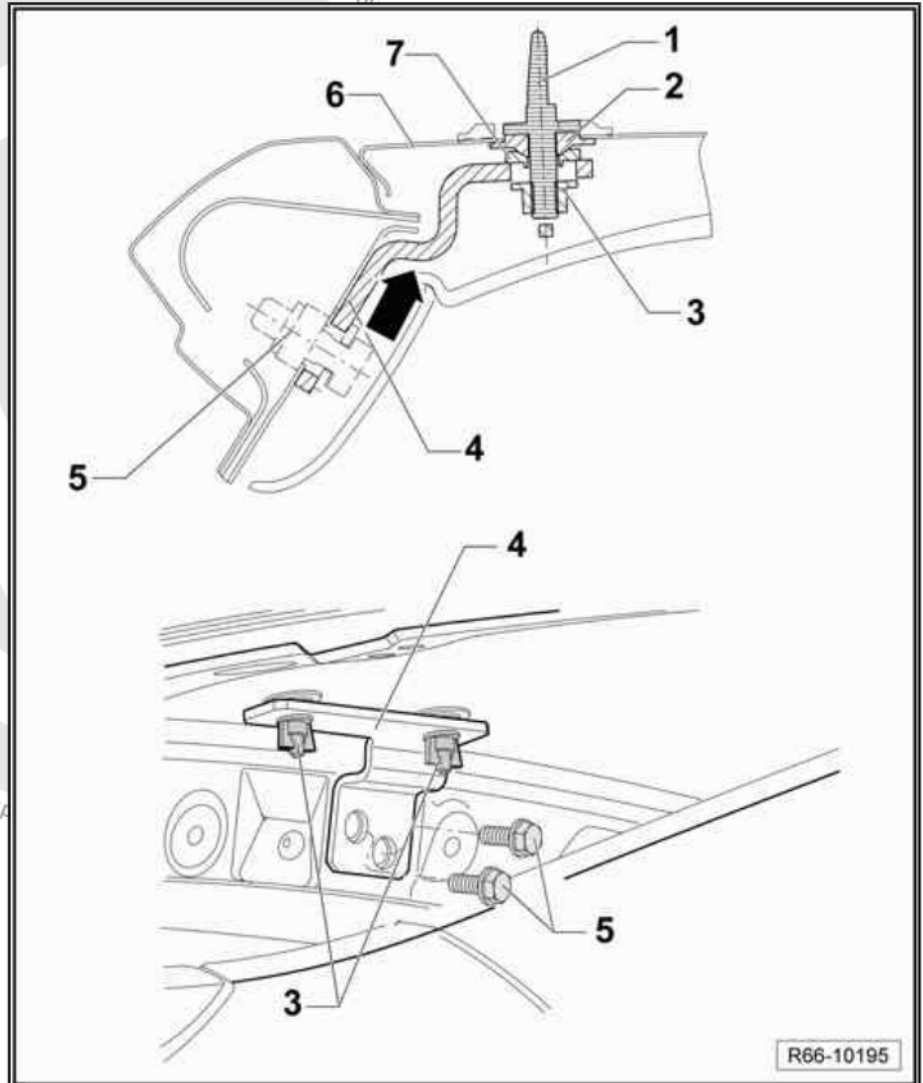
- Carefully place the rack -1- on the roof.
- Install the nuts -3-.
- Install the roof lining ⇒ Body - Internal assembly works; Rep. gr. 70 ; Lining / insulation .



3.3 Roof rack fastening support (Crossfox) - Assembly overview



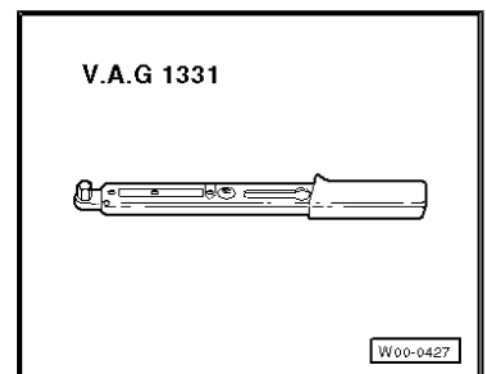
- 1 - Guide pin
 - ☐ replacement part
 - ☐ Centering/positioning of guide rings -2-and -7-.
- 2 - Centering guide ring - conic
 - ☐ Distributes load in relation to roof curvature.
- 3 - Nut
 - ☐ replacement part
- 4 - Rack fastening support
 - ☐ Adjust position in relation to roof, pushing it towards the -arrow-.
- 5 - Bolt
 - ☐ Torque: 20 Nm
- 6 - Roof
- 7 - Centering guide ring - concave
 - ☐ Distributes load in relation to roof curvature.



3.4 Roof rack fastening support (Crossfox) - replace

Special tools and workshop equipment required

- ◆ Torque wrench - 5 to 50Nm (1/2" drive) - VAG 1331-





Removal:

- Remove roof lining ⇒ General body repairs, interior; Rep. gr. 70 ; Lining / insulation .
- Remove nuts -3- .
- Carefully remove the rack -1-.
- Remove the bolts -5-.
- Remove the support -2-.

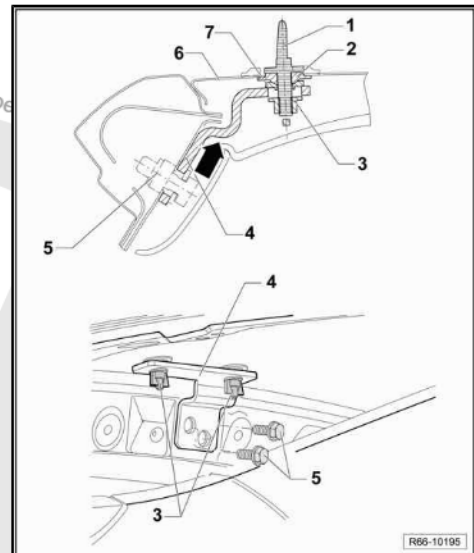
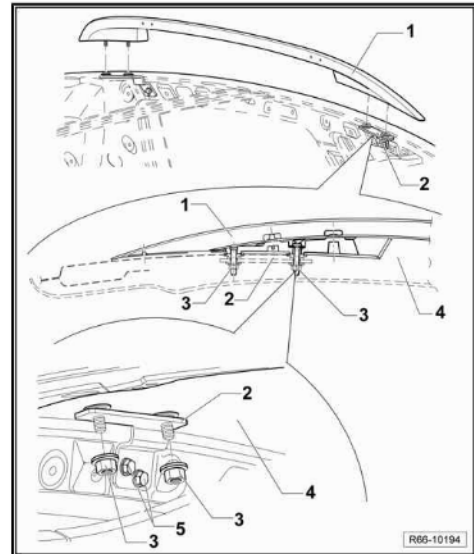
Installation:



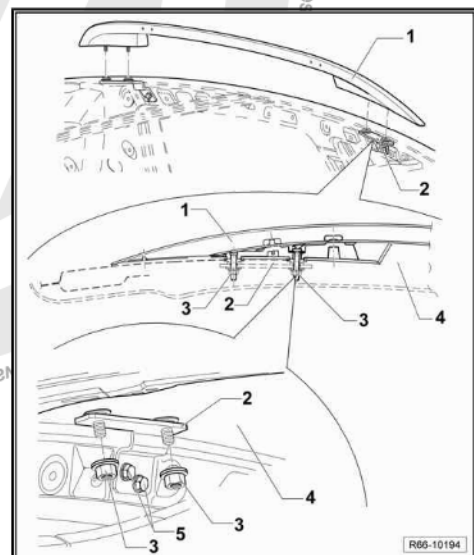
Note

The new support has a guide pin -1- to position guide rings -2- and -7-.

- Place the support so the guide pin -1- adjust position of guide rings -2- and -7-.
- Install screws -5- and push support -2- until immobilizing guide rings -2- and -7-.



- Remove nuts -3- and guide pin -1-.
- Carefully place the rack -1- on the roof.
- Install the nuts -3-.
- Install the roof lining ⇒ Body - Internal assembly works; Rep. gr. 70 ; Lining / insulation .



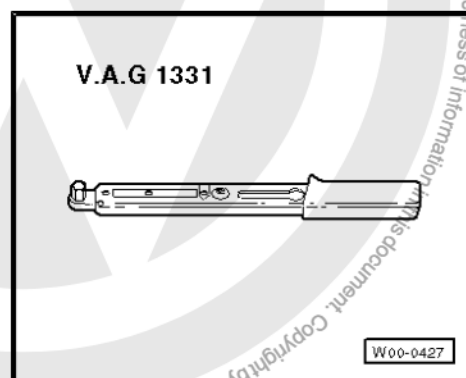
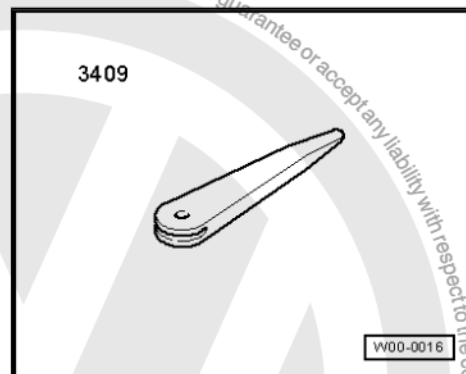


3.5 Roof rack (Spacefox / Suran) - remove and install

Special tools and workshop equipment required

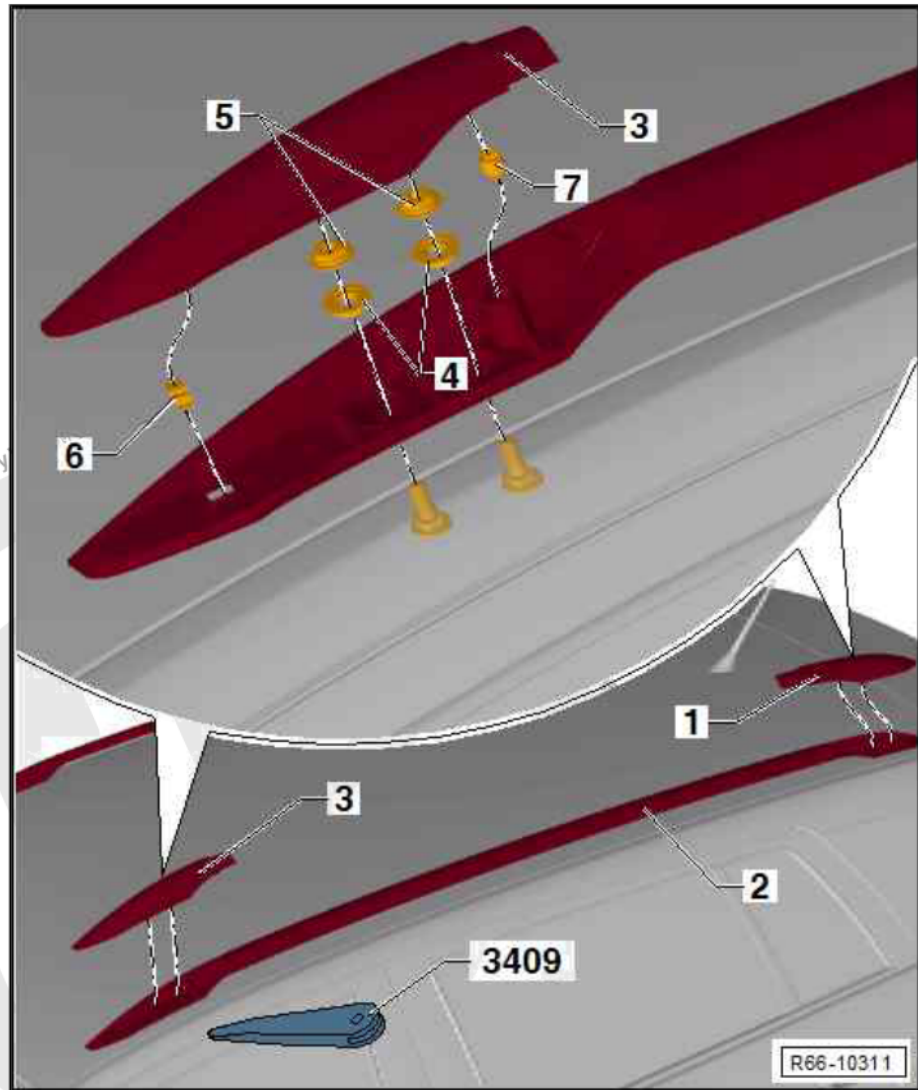
- ◆ Wedge - 3409- or scraper (5 parts) - VW 037-

Torque wrench - 5 to 50 Nm(1/2" drive) - VAG 1331-

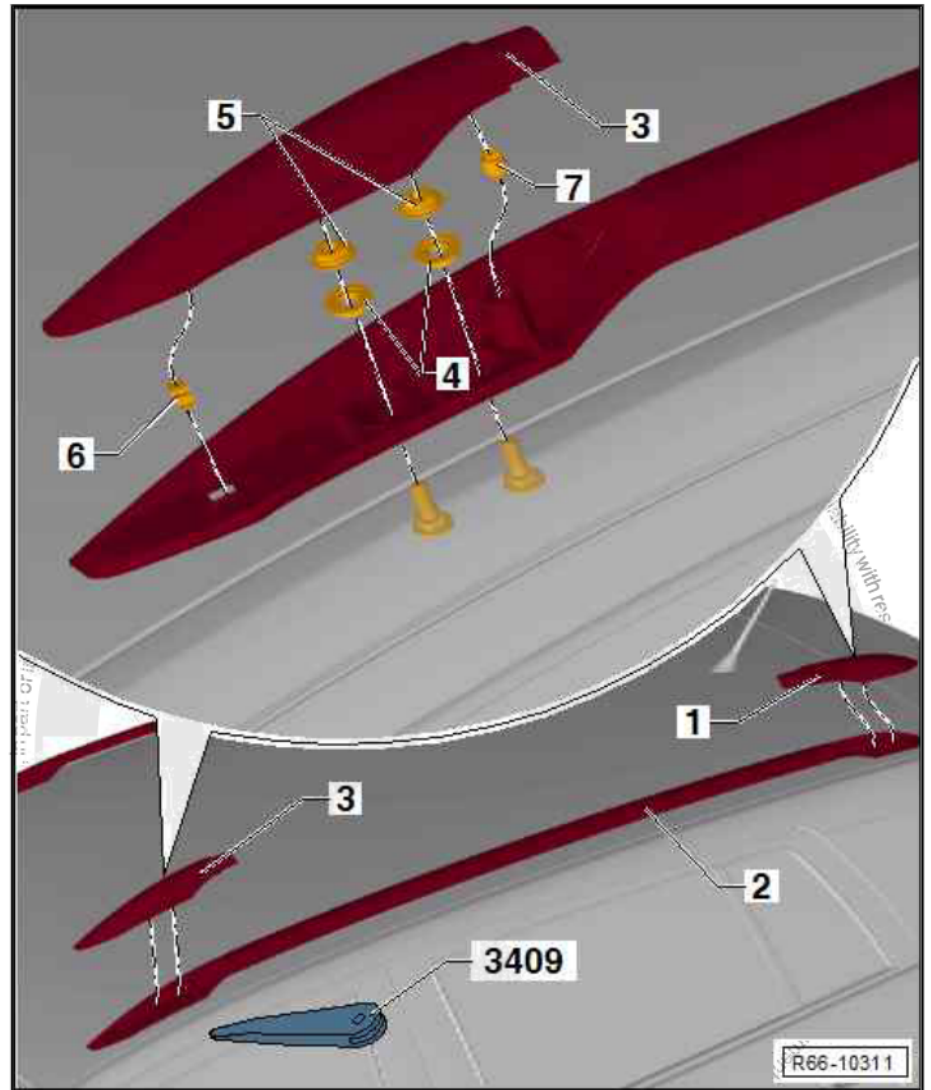




- 1 - Rear fastening cover
 - ☐ Disengage using the wedge - 3409- .
- 2 - Roof rack
- 3 - Front fastening cover
 - ☐ Disengage using the wedge - 3409- .
- 4 - Spherical washer
 - ☐ 2 units
- 5 - Nut
 - ☐ 4 units
 - ☐ Torque: 20 Nm
- 6 - Fastening clip
 - ☐ Replace, as required
- 7 - Fitting pin
 - ☐ Replace, as required



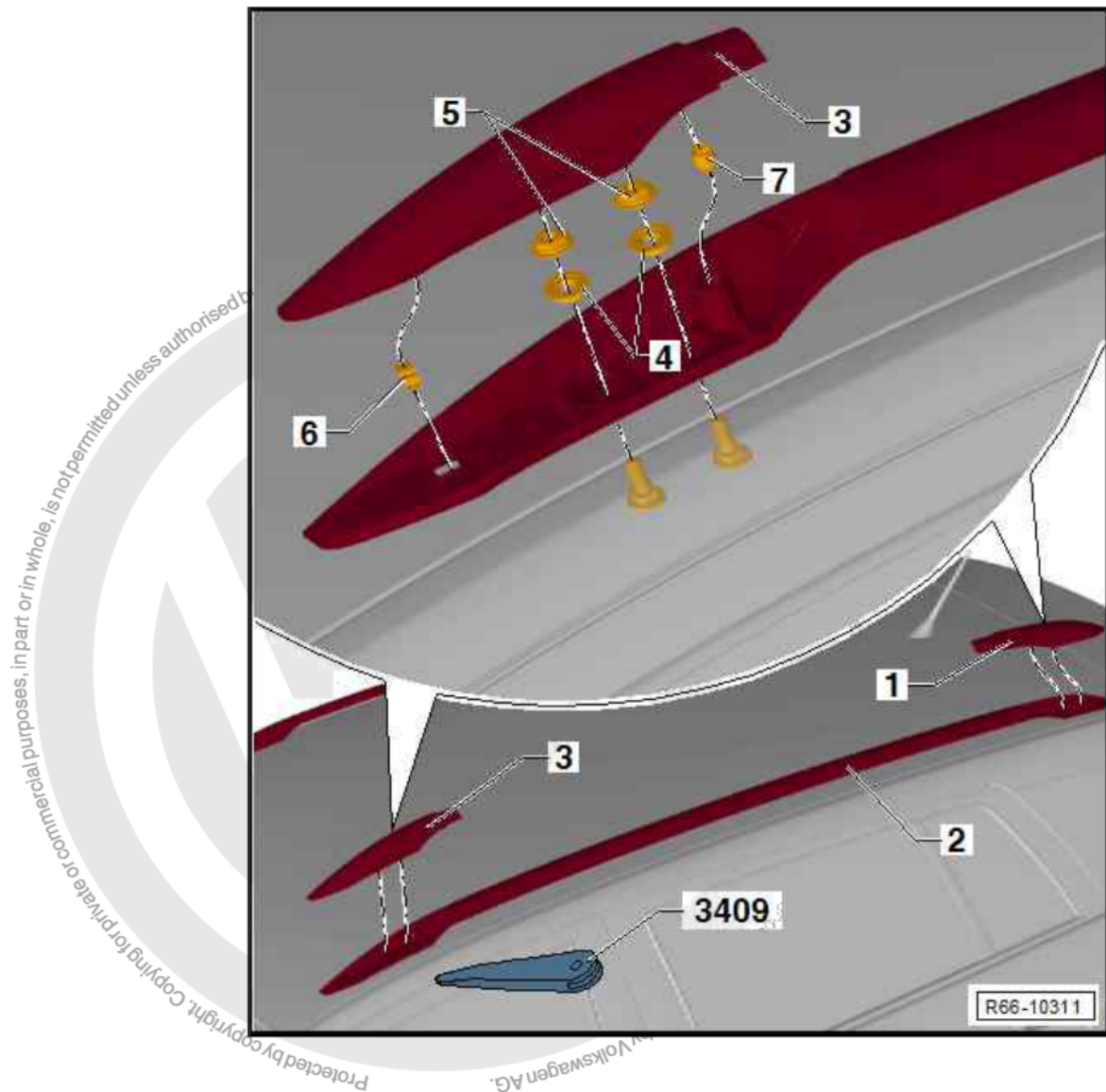
Removal:



- Remove front -3-and rear -1- fastening covers.
- Remove nuts -5- and washers -4-.
- Carefully remove the rack -2-.

Installation:

- Place the rack under the roof.



- Install spherical washers -4- and install nuts -5-.
- Tighten evenly the securing bolts, first from front and then from rear fastening.
- Install front -3-and rear -1- fastening covers.



3.6 Roof rack fastening support (Spacefox / Suran) - Assembly overview

1 - Nut

- ☐ 2 units
- ☐ Torque: 20 Nm

2 - Spherical washer

- ☐ 2 units

3 - Supporting plate with seal

- ☐ PE Foam



Note

The PE foam seal is essential to prevent leaking to inside the vehicle.

4 - Washer

5 - Bolt

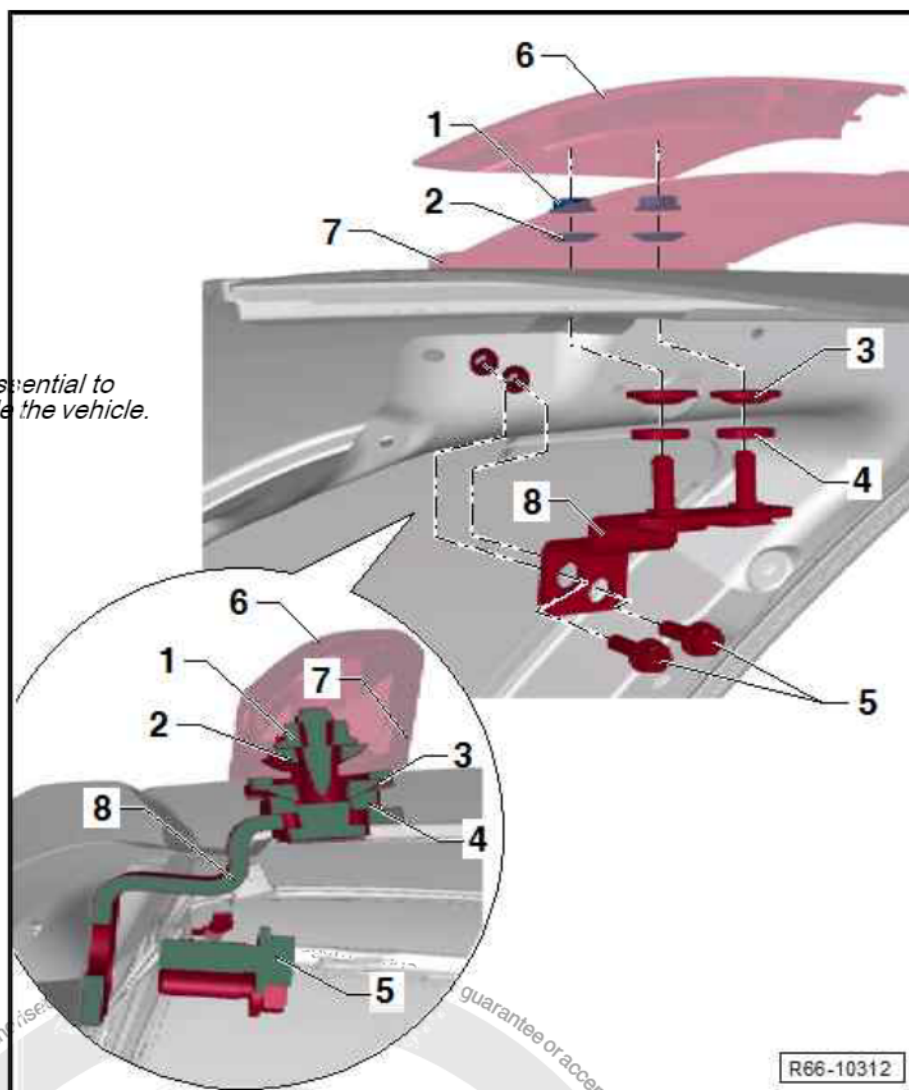
- ☐ 2 units
- ☐ Torque: 20 Nm

6 - Fastening cover

7 - Roof rack

- ☐ Remove and install
⇒ [page 181](#)

8 - Roof rack fastening support



3.7 Roof rack fastening support (Spacefox / Suran) - replace

Removal:

- Remove the roof rack ⇒ [page 181](#) .
- Remove roof lining ⇒ General body repairs, interior; Rep. gr. 70 ; Lining / insulation .



- Remove securing bolts -5- from support.

Installation:

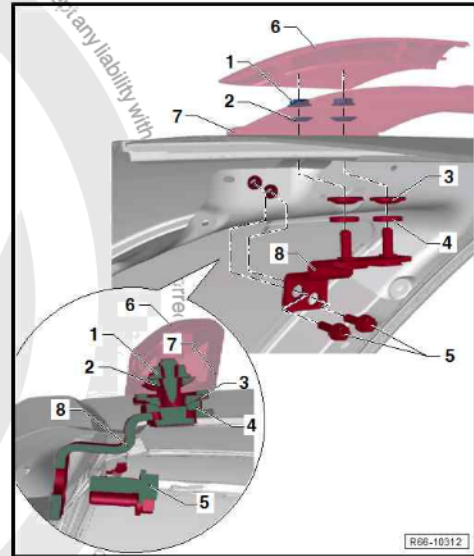
- Place the support -8-, and install securing bolts -5- to support.



Note

Check in advance the conditions of the PE foam in the supporting plate with seal -3- to avoid potential leaking.

- Remove roof lining ⇒ General body repairs, interior; Rep. gr. 70 ; Lining / insulation .
- Install the roof rack ⇒ [page 181](#) .

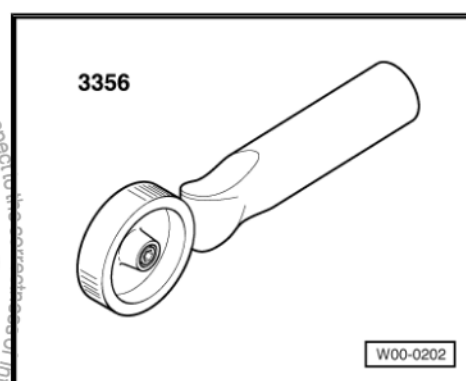
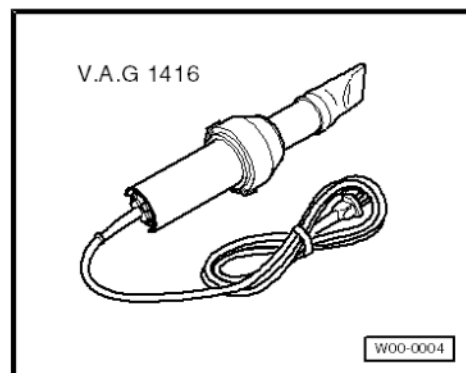




4 Inscriptions

Special tools and workshop equipment required

- ◆ Hot air blower - VAG 1416-



- ◆ Pressure roll - 3356-

4.1 Volkswagen Badge - replace



WARNING

- ◆ When handling chemicals follow the safety instructions ⇒ Chemical Products Manual; Rep. gr. 00
- ◆ Assignment of Chemical Materials ⇒ Electronic Parts Catalogue "ETKA"

Removal:

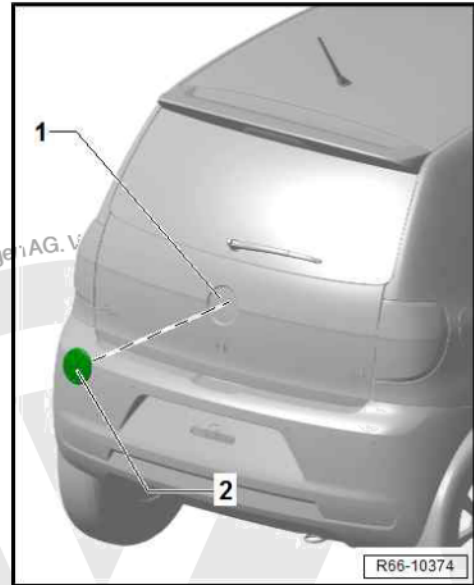


Note

Before removing, heat the badge -2- using the hot air blower - VAG 1416-



Fox:

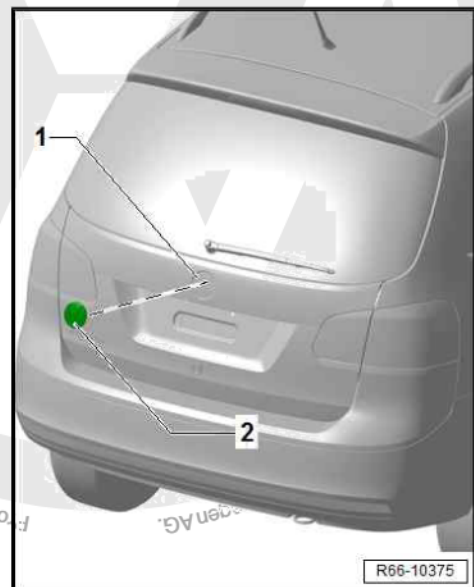


Spacefox / Suran:

- Clean the badge gluing area -1- on the rear lid with the adhesive remover - D 002 000 A2- . Rub the surface with a cloth until it is completely dry.

Installation:

- Remove the liner from the double-sided tape, position the badge -2- on the rear lid and attach it.



4.2 Model lettering (Fox) - replace



WARNING

- ◆ When handling chemicals follow the safety instructions ⇒ Chemical Products Manual; Rep. gr. 00
- ◆ Assignment of Chemical Materials ⇒ Electronic Parts Catalogue "ETKA"

Removal:



Note

Before removal, you must heat up the badge with the hot air blower - VAG 1416- .

- Detach the badge with a plastic scraper.



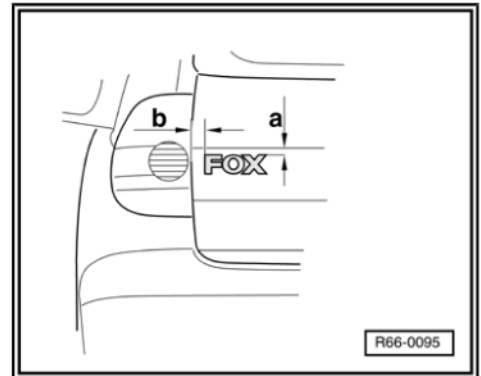
- Clean rear hatch using the adhesive remover - D 002 000 A2- , and apply the cleaning solution - D 009 401 04- . Rub the surface with a cloth until it is completely dry.

Installation:

- Remove the double-sided tape liner and glue the badge as indicated. Use pressure roll - 3356-

a = 15 mm

b = 35 mm



4.3 Version lettering (Fox) - replace



WARNING

- ◆ When handling chemicals follow the safety instructions ⇒ Chemical Products Manual; Rep. gr. 00
- ◆ Assignment of Chemical Materials ⇒ Electronic Parts Catalogue "ETKA"

Removal:



Note

Heat the badge using the hot air blower - VAG 1416- prior to removal

- Detach the badge with a plastic scraper.
- Clean the boot lid using the adhesive remover - D 002 000 A2- , and apply the cleaning solution - D 009 401 04- . Rub the surface with a cloth until it is completely dry.

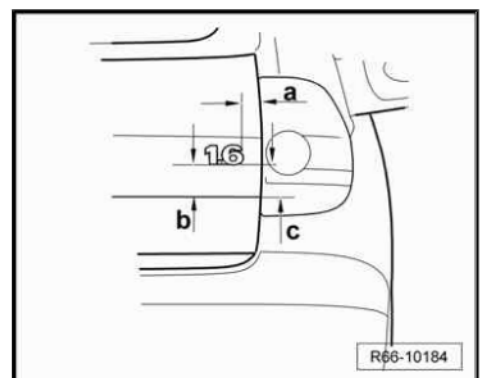
Installation:

- Remove the double-sided tape liner and glue the badge as indicated. Use the pressure roll - 3356- .

a = 34 mm

b = 95.2 mm

c = 90 mm





4.4 Version lettering (Fox - iMotion) - replace



WARNING

- ◆ *When handling chemicals follow the safety instructions ⇒ Chemical Products Manual; Rep. gr. 00*
- ◆ *Assignment of Chemical Materials ⇒ Electronic Parts Catalogue "ETKA"*

Removal:



Note

Heat the badge using the hot air blower - VAG 1416- prior to removal

- Detach the badge with a plastic scraper.
- Clean rear hatch using the adhesive remover - D 002 000 A2- , and apply the cleaning solution - D 009 401 04- . Rub the surface with a cloth until it is completely dry.

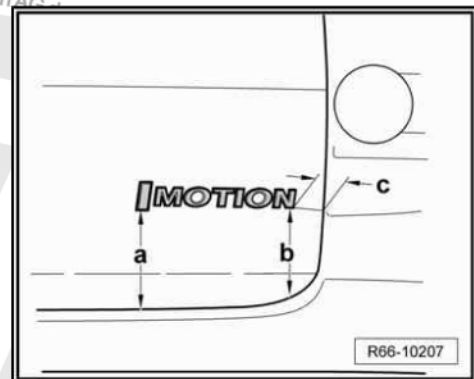
Installation:

- Remove the double-sided tape liner and glue the badge as indicated. Use the pressure roll - 3356-

a = 98.2 mm

b = 85.2 mm

c = 27.45mm



4.5 "Total Flex" badge - replace



WARNING

- ◆ *When handling chemicals follow the safety instructions ⇒ Chemical Products Manual; Rep. gr. 00*
- ◆ *Assignment of Chemical Materials ⇒ Electronic Parts Catalogue "ETKA"*

Removal:



Note

Before removal, you must heat up the badge with the hot air blower - VAG 1416- .

- Detach the badge with a plastic scraper.

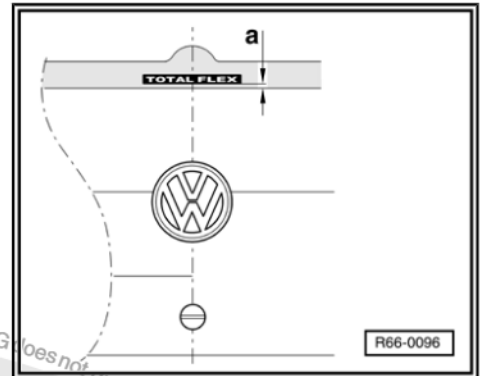


- Clean rear hatch using the adhesive remover - D 002 000 A2- , and apply the cleaning solution - D 009 401 04- . Rub the surface with a cloth until it is completely dry.

Installation:

- Remove the double-sided tape liner and glue the badge as indicated. Use the pressure roll - 3356- .

a = 6 mm



4.6 Version lettering (Bluemotion) - replace



WARNING

- ◆ *When handling chemicals follow the safety instructions ⇒ Chemical Products Manual; Rep. gr. 00*
- ◆ *Assignment of Chemical Materials ⇒ Electronic Parts Catalogue "ETKA"*

Removal:



Note

Heat the badge using the hot air blower - VAG 1416- prior to removal

- Detach the badge with a plastic spatula.
- Clean rear hatch using the adhesive remover - D 002 000 A2- , and apply the cleaning solution - D 009 401 04- . Rub the surface with a cloth until it is completely dry.



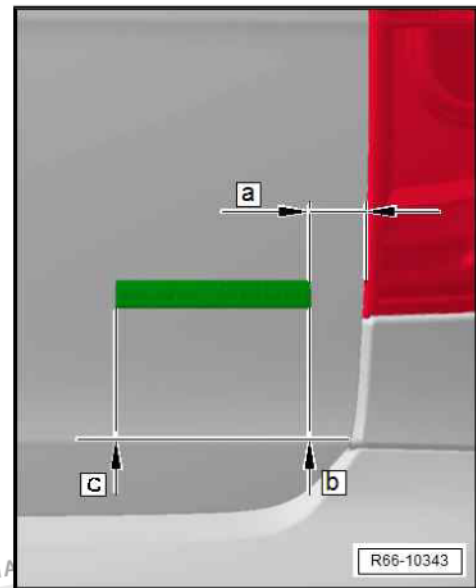
Installation:

- Remove the double-sided tape liner and glue the badge as indicated. Use the pressure roll - 3356- .

a = 30.7 mm

b = 65.1 mm

b = 64.7 mm



4.7 “Spacefox / Suran” lettering on rear lid - replace



WARNING

- ◆ When handling chemicals follow the safety instructions → Chemical Products Manual; Rep. gr. 00
- ◆ Assignment of Chemical Materials → Electronic Parts Catalogue “ETKA”

Removal:



Note

Heat the badge using the hot air blower - VAG 1416- prior to removal

- Detach badge -1- using a plastic scraper.
- Clean rear hatch using the adhesive remover - D 002 000 A2- , and apply the cleaning solution - D 009 401 04- . Rub the surface with a cloth until it is completely dry.



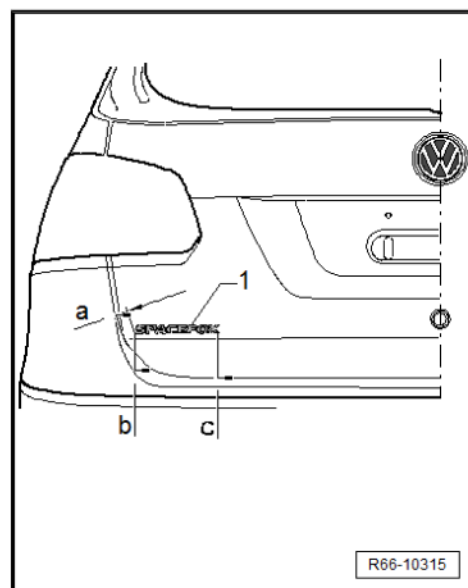
Installation:

- Remove badge liner and glue it as indicated. Use pressure roll - 3356-

a = 27.1 mm

b = 53.3 mm

c = 91.3 mm



4.8 “1.6” lettering on rear lid (Spacefox / Sur-an) - replace



WARNING

- ◆ *When handling chemicals follow the safety instructions ⇒ Chemical Products Manual; Rep. gr. 00*
- ◆ *Assignment of Chemical Materials ⇒ Electronic Parts Catalogue “ETKA”*

Removal:



Note

Heat the badge using the hot air blower - VAG 1416- prior to removal

- Detach badge -1- using a plastic scraper.
- Clean rear hatch using the adhesive remover - D 002 000 A2-, and apply the cleaning solution - D 009 401 04-. Rub the surface with a cloth until it is completely dry.



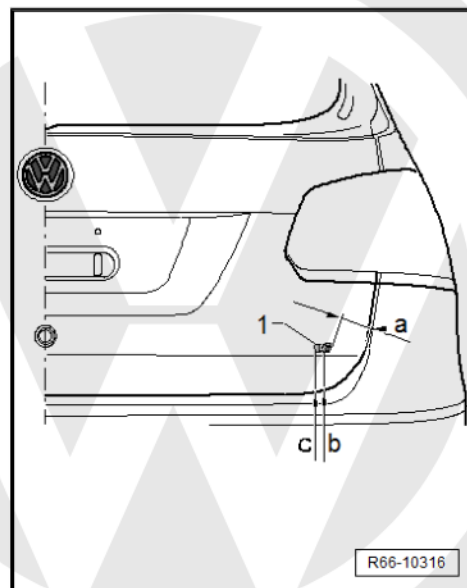
Installation:

- Remove badge liner and glue it as indicated. Use the pressure roll - 3356- .

a = 29.4 mm

b = 64.3 mm

c = 80.8 mm



4.9 Version lettering (Spacefox / Suran - Imotion) - replace



WARNING

- ◆ *When handling chemicals follow the safety instructions ⇒ Chemical Products Manual; Rep. gr. 00*
- ◆ *Assignment of Chemical Materials ⇒ Electronic Parts Catalogue "ETKA"*

Removal:



Note

Heat the badge using the hot air blower - VAG 1416- prior to removal

- Detach the badge -1- with a plastic scraper.
- Clean rear hatch using the adhesive remover - D 002 000 A2- , and apply the cleaning solution - D 009 401 04- . Rub the surface with a cloth until it is completely dry.



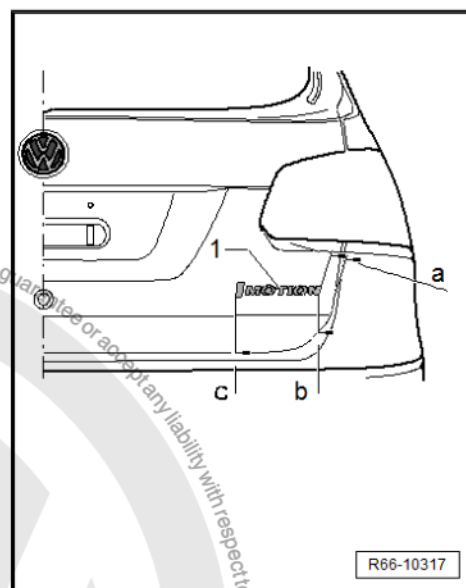
Installation:

- Remove the double-sided tape liner and glue the badge as indicated. Use the pressure roll - 3356- .

a = 27.2 mm

b = 56.9 mm

c = 91.2 mm



4.10 Badge "Rock in Rio" (Gol Rock in Rio MY 12 ►) - replace



WARNING

- ◆ *When handling chemicals follow the safety instructions ⇒ Chemical Products Manual; Rep. gr. 00*
- ◆ *Assignment of Chemical Materials ⇒ Electronic Parts Catalogue "ETKA"*

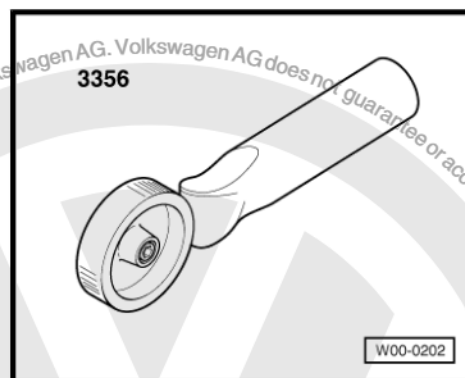
Special tools and workshop equipment required

- ◆ Hot air blower - VAG 1416-





◆ Pressure roll - 3356-



Removal:



Note

Heat the badge using the hot air blower - VAG 1416- prior to removal

- Detach the badge with a plastic spatula.
- Clean rear hatch using the adhesive remover - D 002 000 A2- , and apply the cleaning solution - D 009 401 04- . Rub the surface with a cloth until it is completely dry.

Installation:

- Remove badge liner and glue it as indicated. Use the pressure roll - 3356- .

a = 55.5 mm

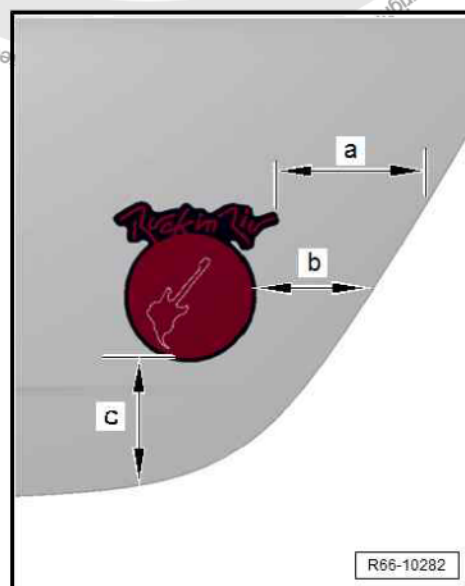
b = 38.6mm

c = 54 mm



Note

Operating temperature approx. 20°C.



4.11 Badge "Rock in Rio" (Gol Rock in Rio MY 14 ►) - replace



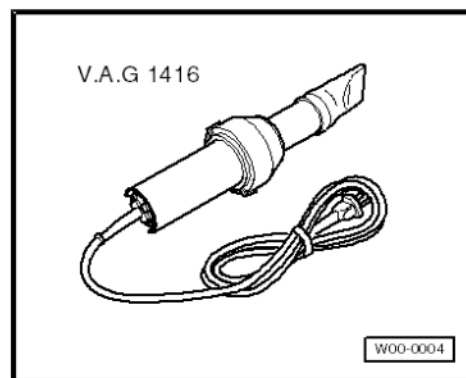
WARNING

- ◆ *When handling chemicals follow the safety instructions ⇒ Chemical Products Manual; Rep. gr. 00*
- ◆ *Assignment of Chemical Materials ⇒ Electronic Parts Catalogue "ETKA"*

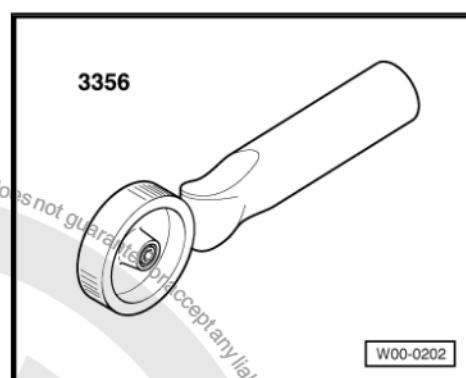
Special tools and workshop equipment required



◆ Hot air blower - VAG 1416-



◆ Pressure roll - 3356-



Removal:



Note

Heat the badge using the hot air blower - VAG 1416- prior to removal

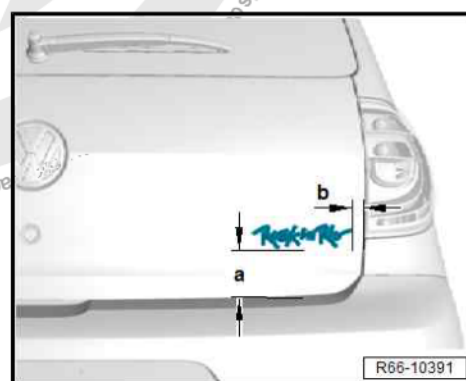
- Detach the badge with a plastic spatula.
- Clean rear hatch using the adhesive remover - D 002 000 A2- , and apply the cleaning solution - D 009 401 04- . Rub the surface with a cloth until it is completely dry.

Installation:

- Remove badge liner and glue it as indicated. Use the pressure roll - 3356- .

a = 75.5 mm

b = 22.6 mm





4.12 "Brazilian Soccer Team" Badge (Fox Seleção MY 14 ➤) - remove and install

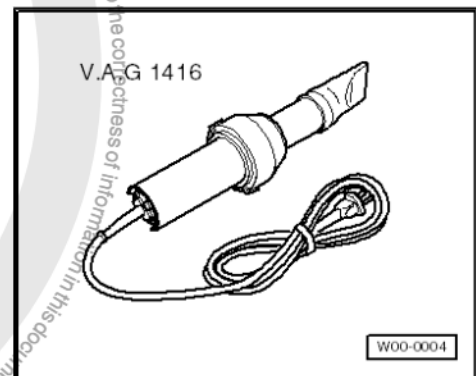


WARNING

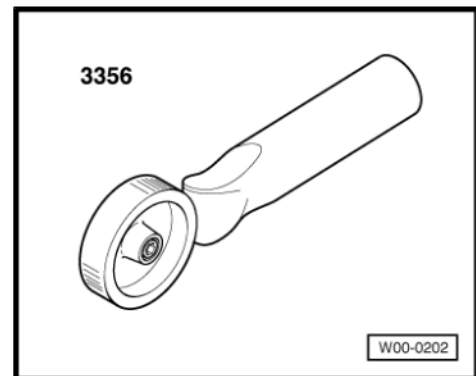
- ◆ *When handling chemicals follow the safety instructions ⇒ Chemical Products Manual; Rep. gr. 00*
- ◆ *Assignment of Chemical Materials ⇒ Electronic Parts Catalogue "ETKA"*

Special tools and workshop equipment required

- ◆ Hot air blower - VAG 1416-



- ◆ Pressure roll - 3356-



Removal:



Note

Heat the badge using the hot air blower - VAG 1416- prior to removal

- Detach the badge with a plastic spatula.
- Clean rear hatch using the adhesive remover - D 002 000 A2- , and apply the cleaning solution - D 009 401 04- . Rub the surface with a cloth until it is completely dry.

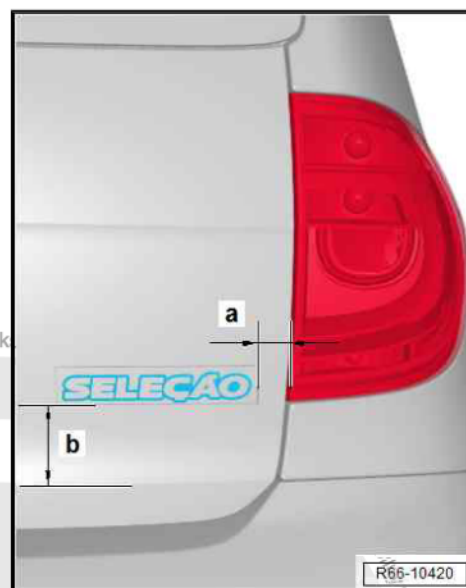


Installation:

- Align the liner -1- with the gap lines and the end of the rear cover, and place the badge -2-. Use the pressure roll - 3356- .

a = 24.9 mm

b = 62.8 mm



4.13 “Brazilian Flag” Badge (Fox Seleção MY 14 ►) - remove and install



WARNING

- ◆ *When handling chemicals follow the safety instructions ⇒ Chemical Products Manual; Rep. gr. 00*
- ◆ *Assignment of Chemical Materials ⇒ Electronic Parts Catalogue “ETKA”*

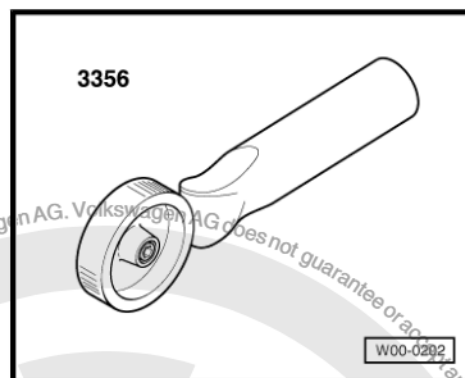
Special tools and workshop equipment required

- ◆ Hot air blower - VAG 1416-





◆ Pressure roll - 3356-



Removal:



Note

Heat the badge using the hot air blower - VAG 1416- prior to removal

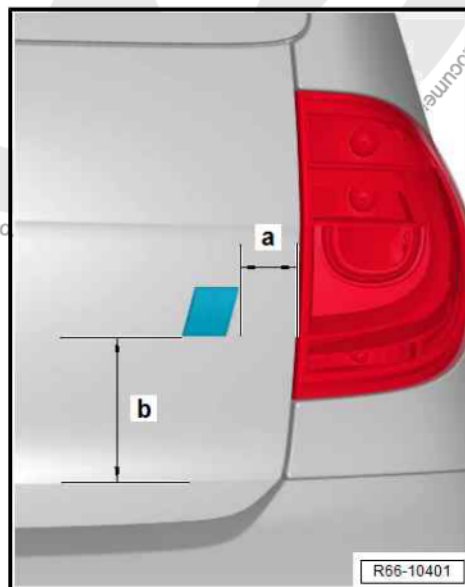
- Detach the badge with a plastic spatula.
- Clean rear hatch using the adhesive remover - D 002 000 A2- , and apply the cleaning solution - D 009 401 04- . Rub the surface with a cloth until it is completely dry.

Installation:

- Align the liner -1- with the gap lines and the end of the rear cover, and place the badge -2-. Use the pressure roll - 3356- .

a = 12.7 mm

b = 43.1 mm



4.14 Model lettering (Fox) - replace



WARNING

- ◆ *When handling chemicals follow the safety instructions ⇒ Chemical Products Manual; Rep. gr. 00*
- ◆ *Assignment of Chemical Materials ⇒ Electronic Parts Catalogue "ETKA"*



Removal:



Note

Before removal, you must heat up the badge with the hot air blower - VAG 1416- .

- Detach the badge with a plastic scraper.
- Clean rear hatch using the adhesive remover - D 002 000 A2- , and apply the cleaning solution - D 009 401 04- . Rub the surface with a cloth until it is completely dry.

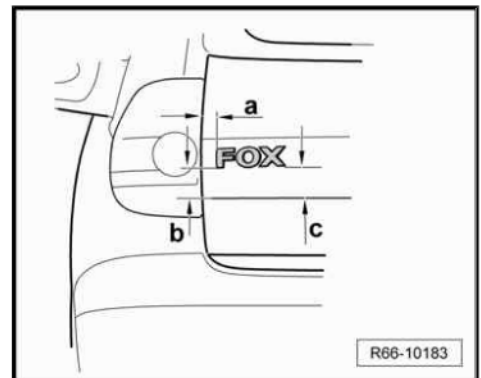
Installation:

- Remove the double-sided tape liner and glue the badge as indicated. Use the pressure roll - 3356- .

a = 30.5 mm

b = 81.6 mm

b = 96.5 mm



4.15 Model lettering (Crossfox) - replace



WARNING

- ◆ *When handling chemicals follow the safety instructions ⇒ Chemical Products Manual; Rep. gr. 00*
- ◆ *Assignment of Chemical Materials ⇒ Electronic Parts Catalogue "ETKA"*

Removal:



Note

Before removal, you must heat up the badge with the hot air blower - VAG 1416- .

- Detach the badge with a plastic scraper.
- Clean rear hatch using the adhesive remover - D 002 000 A2- , and apply the cleaning solution - D 009 401 04- . Rub the surface with a cloth until it is completely dry.



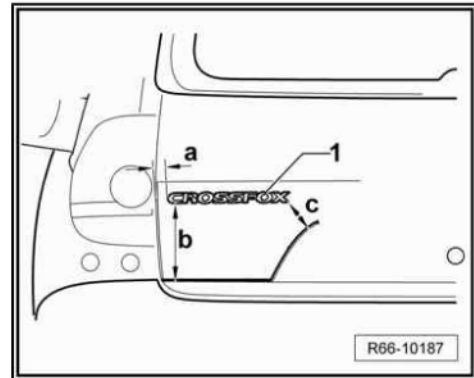
Installation:

- Remove the double-sided tape liner and glue the badge as indicated. Use the pressure roll - 3356- .

a = 19.1 mm

b = 133.4 mm

b = 59.7 mm



4.16 "Fox-shape" badge on door (Crossfox) - replace



WARNING

- ◆ When handling chemicals follow the safety instructions ⇒ Chemical Products Manual; Rep. gr. 00
- ◆ Assignment of Chemical Materials ⇒ Electronic Parts Catalogue "ETKA"

Removal:



Note

Heat the badge using the hot air blower - VAG 1416- prior to removal

- Detach badge -1- using a plastic scraper.
- Clean door with adhesive remover - D 002 000 A2- and apply cleaning solution - D 009 401 04- . Rub the surface with a cloth until it is completely dry.

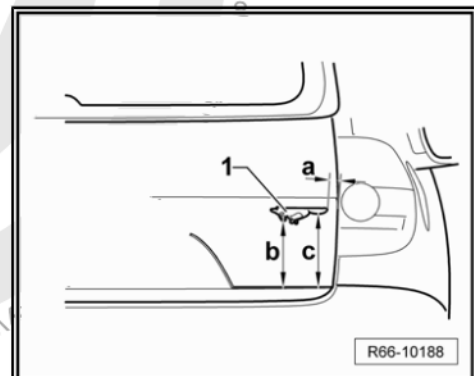
Installation:

- Remove badge liner and glue it as indicated. Use the pressure roll - 3356- .

a = 19 mm

b = 125.5 mm

c = 140.7 mm





4.17 "Silverfox" (Fox BlackFox) lettering on rear lid - replace



WARNING

- ◆ When handling chemicals follow the safety instructions ⇒ Chemical Products Manual; Rep. gr. 00
- ◆ Assignment of Chemical Materials ⇒ Electronic Parts Catalogue "ETKA"

Removal:



Note

Heat badge using the hot air blower - VAG 1416- prior to removal.

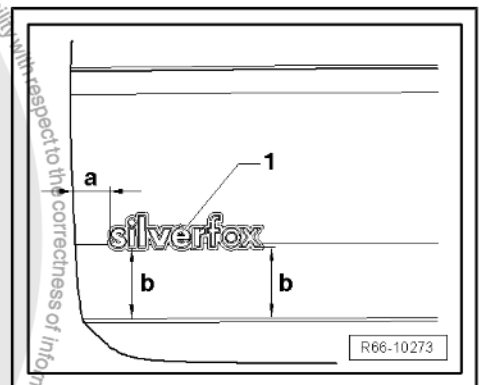
- Detach badge -1- using a plastic scraper.
- Clean rear hatch using the adhesive remover - D 002 000 A2- , and apply the cleaning solution - D 009 401 04- . Rub the surface with a cloth until it is completely dry.

Installation:

- Remove badge liner -1- from the logo and attach as indicated. Use a pressure roll - 3356- .

a = 30 mm

b = 58 mm



4.18 "BlackFox" (Fox BlackFox) Badge on rear door - replace



WARNING

- ◆ When handling chemicals follow the safety instructions ⇒ Chemical Products Manual; Rep. gr. 00
- ◆ Assignment of Chemical Materials ⇒ Electronic Parts Catalogue "ETKA"

Removal:



Note

Heat the badge using the hot air blower - VAG 1416- prior to removal

- Detach badge -1- using a plastic scraper.



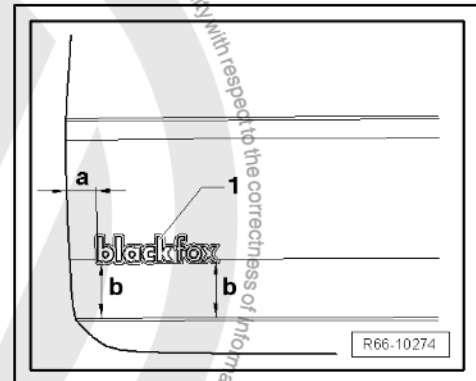
- Clean rear hatch using the adhesive remover - D 002 000 A2- , and apply the cleaning solution - D 009 401 04- . Rub the surface with a cloth until it is completely dry.

Installation:

- Remove badge liner -1- and glue it as indicated. Use the pressure roll - 3356- .

a = 30 mm

b = 58 mm



4.19 "VW Tag" (Rear window - Fox Seleção MY 14 ►) - remove and install



WARNING

- ◆ When handling chemicals follow the safety instructions ⇒ Chemical Products Manual; Rep. gr. 00
- ◆ Assignment of Chemical Materials ⇒ Electronic Parts Catalogue "ETKA"

Removal:



Note

Heat the badge using the hot air blower - VAG 1416- prior to removal

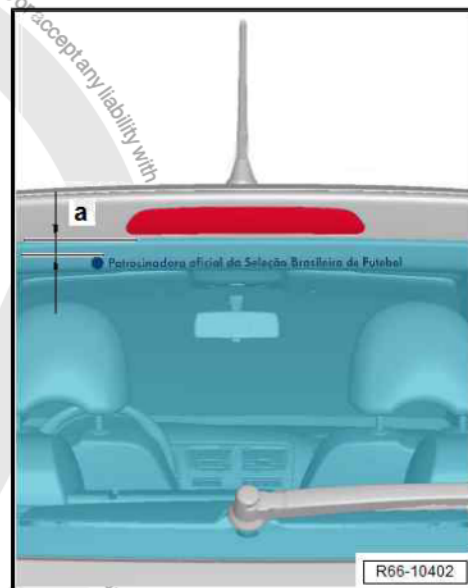
- Detach the badge with a plastic spatula.
- Clean rear window with adhesive remover - D 002 000 A2- and apply cleaning solution - D 009 401 04- . Rub the surface with a cloth until it is completely dry.



Installation:

- Align the liner -1- with the rear window edge line, and place the badge -2-. Use the pressure roll - 3356- .

a = 16.8 mm



4.20 Side badge (Trend) - replace



WARNING

- ◆ When handling chemicals follow the safety instructions ⇒ Chemical Products Manual; Rep. gr. 00
- ◆ Assignment of Chemical Materials ⇒ Electronic Parts Catalogue "ETKA"



1 - Side badge

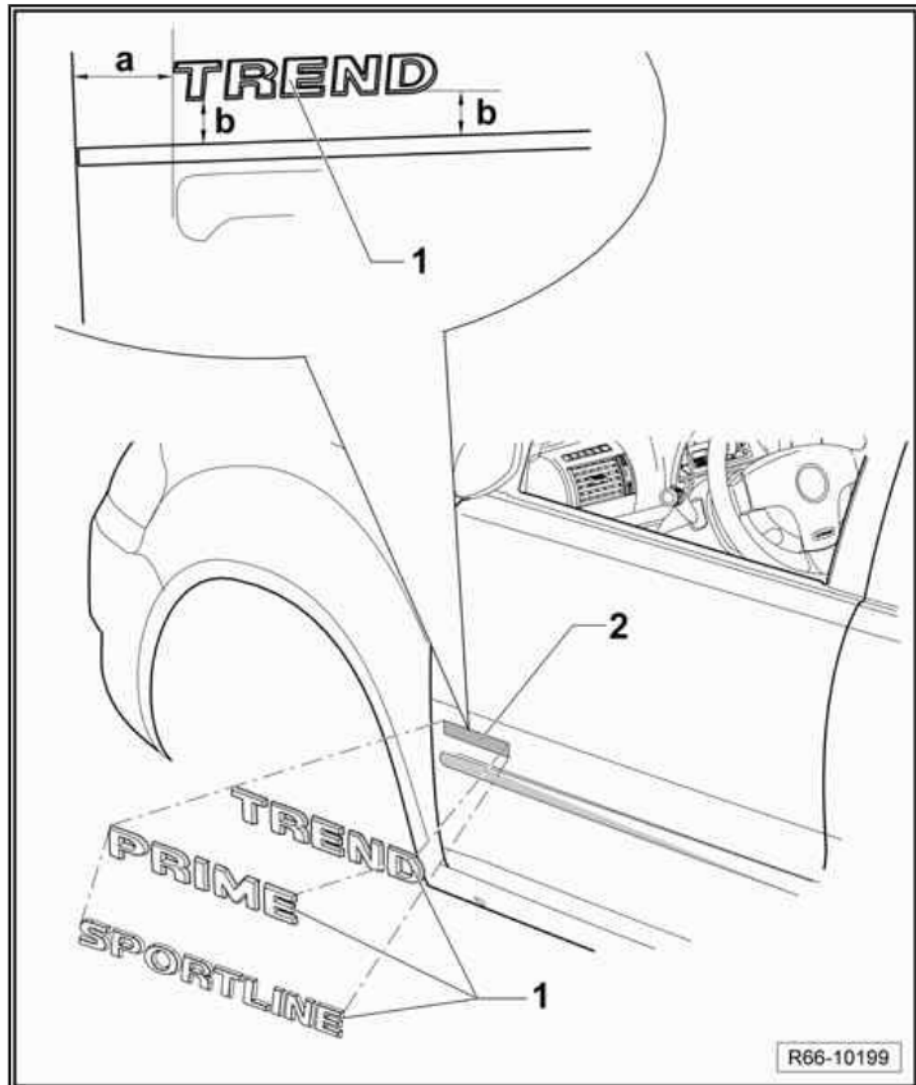
- ☐ Self-adherent
- ☐ Heat badge using the hot air blower - VAG 1416- prior to removal.
- ☐ Remove badge liner and glue it as indicated. Use pressure roll - 3356- . Operating temperature approx. 20°C.

a = 39.8 mm

b = 18 mm

2 - Badge adhesion area

- ☐ Clean the area using adhesive remover - D 002 000 A2- , then apply the cleaning solution - D 009 401 04- . Rub the surface with a cloth until it is completely dry.



4.21 Side lettering - "Silverfox", side (Fox Silverfox) - replace



WARNING

- ◆ When handling chemicals follow the safety instructions ⇒ Chemical Products Manual; Rep. gr. 00
- ◆ Assignment of Chemical Materials ⇒ Electronic Parts Catalogue "ETKA"

Removal:



Note

Before removal, you must heat up the badge with the hot air blower - VAG 1416- .

- Detach the badge with a plastic scraper.



- Clean the boot lid using the adhesive remover - D 002 000 A2- , and apply the cleaning solution - D 009 401 04- . Scrub the surface with a cloth until it is completely dry.

Installation:



Note

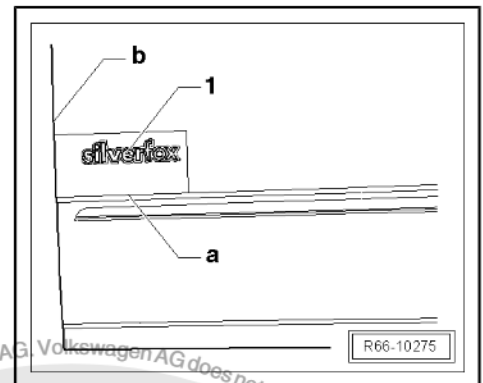
The replacement part has a location mask.

- Remove the liner and position the badge using the edge of the front door -b- and the lower crease -b- as a reference to position the mask. Glue it and press using a pressure roll - 3356- .



Note

Operating temperature approx. 20°C



4.22 Side badge - BlackFox version (Fox BlackFox) - replace



WARNING

- ◆ *When handling chemicals follow the safety instructions → Chemical Products Manual; Rep. gr. 00*
- ◆ *Assignment of Chemical Materials → Electronic Parts Catalogue "ETKA"*

Removal:



Note

Before removal, you must heat up the badge with the hot air blower - VAG 1416- .

- Detach the badge with a plastic scraper.
- Clean rear hatch using the adhesive remover - D 002 000 A2- , and apply the cleaning solution - D 009 401 04- . Rub the surface with a cloth until it is completely dry.

Installation:



Note

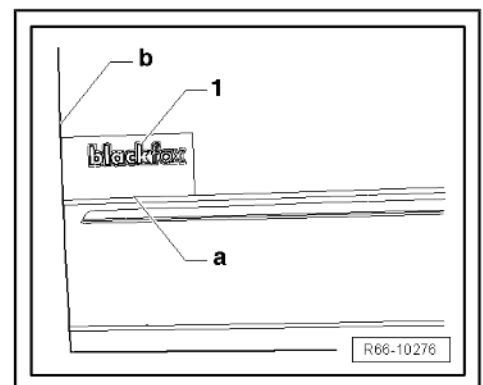
The replacement part has a location mask.

- Remove the liner and position the badge using the edge of the front door -b- and the lower crease -b- as a reference to position the mask. Glue it and press it using a pressure roll - 3356-



Note

Operating temperature approx. 20°C.





4.23 Side version lettering "ITREND" - replace



WARNING

- ◆ When handling chemicals follow the safety instructions ⇒ Chemical Products Manual; Rep. gr. 00
- ◆ Assignment of Chemical Materials ⇒ Electronic Parts Catalogue "ETKA"

Removal:



Note

Before removal, you must heat up the badge with the hot air blower - VAG 1416- .

- Detach the badge with a plastic scraper.
- Clean rear hatch using the adhesive remover - D 002 000 A2- , and apply the cleaning solution - D 009 401 04- . Rub the surface with a cloth until it is completely dry.

Installation:



Note

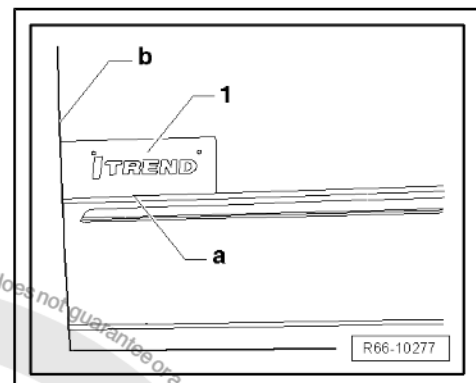
The replacement part has a location mask.

- Remove the liner and position the badge using the edge of the front door -b- and the lower crease -b- as a reference to position the mask. Glue it and press using a pressure roll - 3356- .



Note

Operating temperature approx. 20°C.



4.24 Badge of the "Rock in Rio" version on the front bumper (Gol Rock in Rio MY 14 ➤) - replace



WARNING

- ◆ When handling chemicals follow the safety instructions ⇒ Chemical Products Manual; Rep. gr. 00
- ◆ Assignment of Chemical Materials ⇒ Electronic Parts Catalogue "ETKA"



Removal:



Note

Before removal, you must heat up the badge with the hot air blower - VAG 1416- .

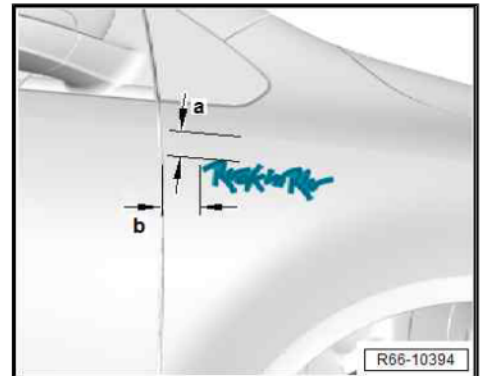
- Detach the badge with a plastic scraper.
- Clean the bumper with adhesive remover - D 002 000 A2- and apply cleaning solution - D 009 401 04- . Rub the surface with a cloth until it is completely dry.

Installation:

- Remove badge liner and glue it as indicated. Use the pressure roll - 3356- .

a = 38 mm

b = 56.5 mm



4.25 "CBF" Badge on the front bumper (Fox Seleção MY 14 ►) - remove and install



WARNING

- ◆ *When handling chemicals follow the safety instructions ⇒ Chemical Products Manual; Rep. gr. 00*
- ◆ *Assignment of Chemical Materials ⇒ Electronic Parts Catalogue "ETKA"*

Removal:



Note

Before removal, you must heat up the badge with the hot air blower - VAG 1416- .

- Detach the badge with a plastic scraper.
- Clean the front bumper with adhesive remover - D 002 000 A2- and apply cleaning solution - D 009 401 04- . Rub the surface with a cloth until it is completely dry.

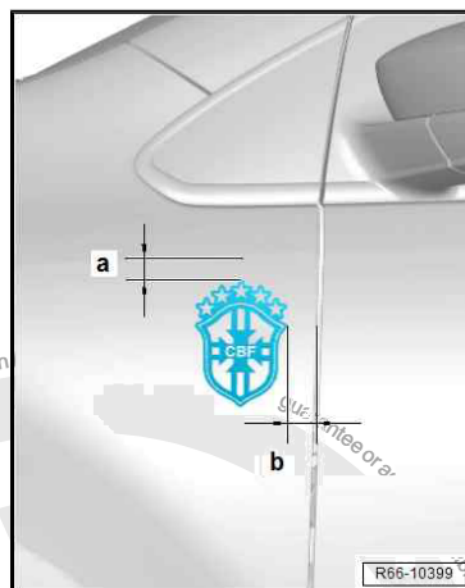


Installation:

- Align the liner -1- with the front bumper edge line, and place the badge -2-. Use the pressure roll - 3356- .

a = 21.2 mm

b = 25.8 mm



4.26 Decorative strip on the front and rear door (Fox Rock in Rio MY 12 ►) - replace

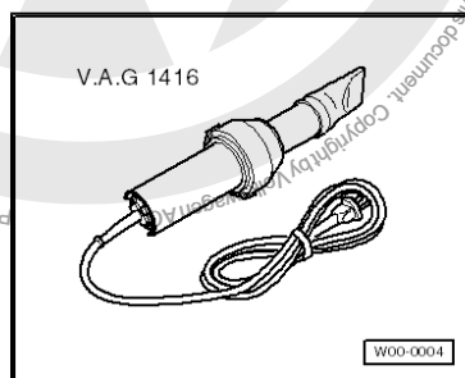


WARNING

- ◆ *When handling chemicals follow the safety instructions ⇒ Chemical Products Manual; Rep. gr. 00*
- ◆ *Assignment of Chemical Materials ⇒ Electronic Parts Catalogue "ETKA"*

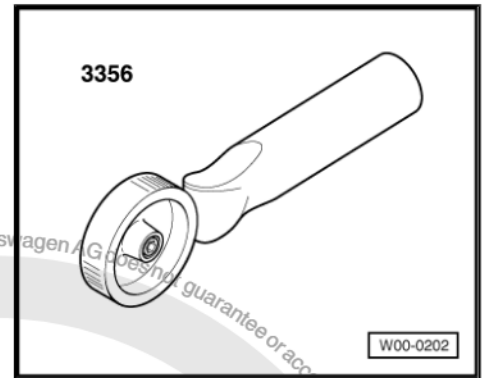
Special tools and workshop equipment required

- ◆ Hot air blower - VAG 1416-



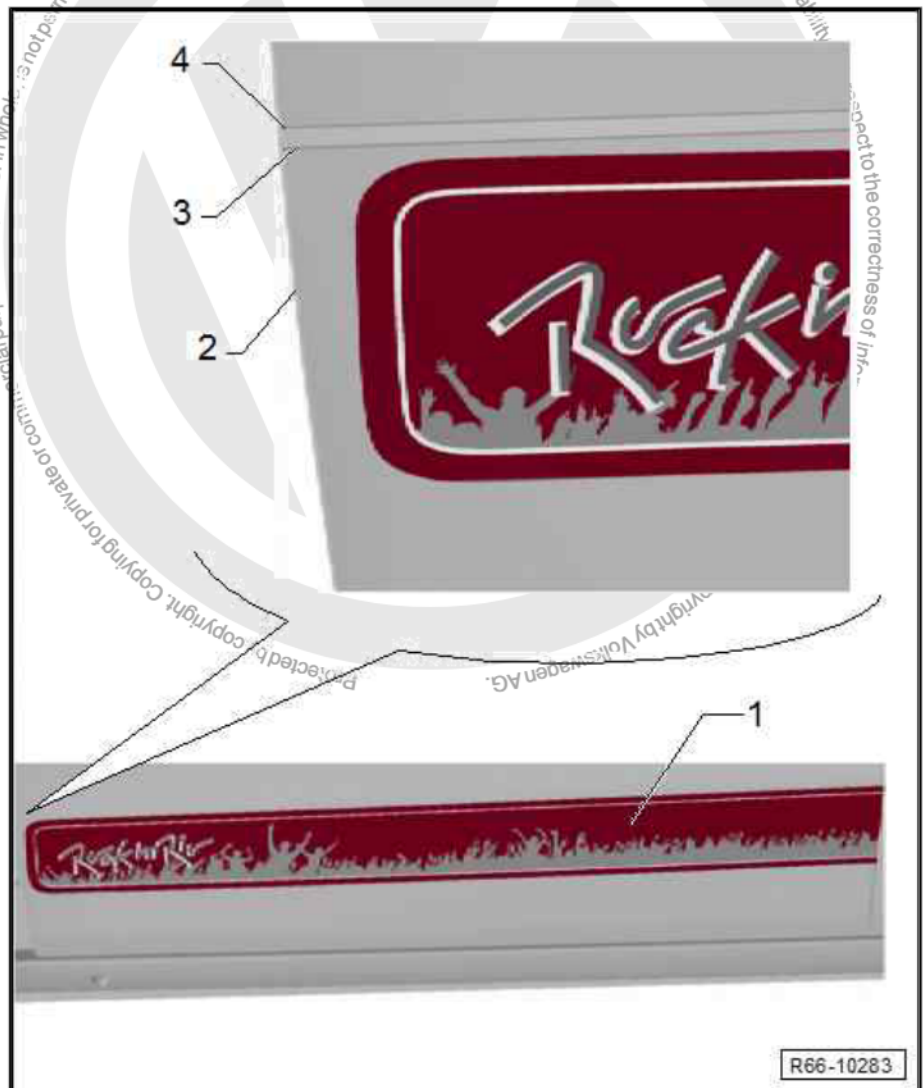


◆ Pressure roll - 3356-



1 - Front door fixed window

- ☐ Self-adherent
- ☐ Before removing, you must heat up the lining with the hot air blower - VAG 1416- .
- ☐ When installing:
 - Clean the adhesion area with the cleaning solution - D 009 401 04- . Rub the surface with a cloth until it is completely dry.
 - Upon installation, heat previously the adhesion area for lining, with the Hot air blower - VAG 1416- .
 - Remove the protective liner, position the plastic foil (mask) of the decorative stripe in relation to the door crease -3-, press carefully in order not to trap air bubbles under the stripe, and then, press strongly using the pressure roll - 3356- . Operating temperature approx. 20°C
 - Remove the positioning mask from the decorative stripe.



2 - Door edge

- ☐ for positioning of decorative strip mask

3 - Lower crease of the door

- ☐ for positioning of decorative strip mask

4 - Upper crease of the door



4.27 Decorative strip on the front and rear door (Fox Rock in Rio MY 14 ►) - replace

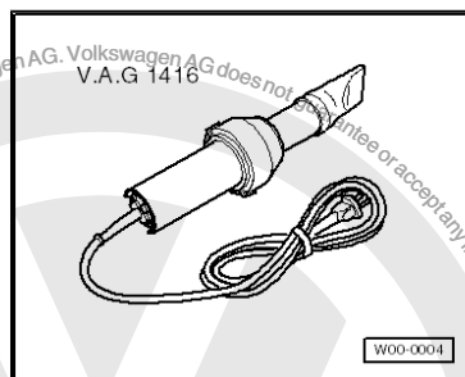


WARNING

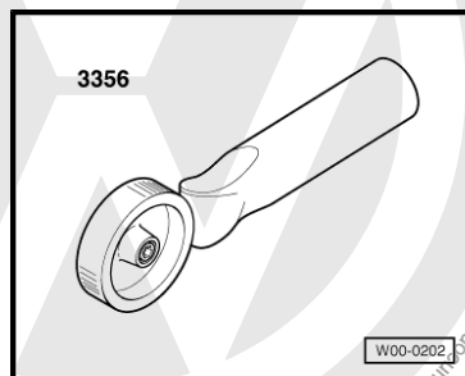
- ◆ *When handling chemicals follow the safety instructions ⇒ Chemical Products Manual; Rep. gr. 00*
- ◆ *Assignment of Chemical Materials ⇒ Electronic Parts Catalogue "ETKA"*

Special tools and workshop equipment required

- ◆ Hot air blower - VAG 1416-



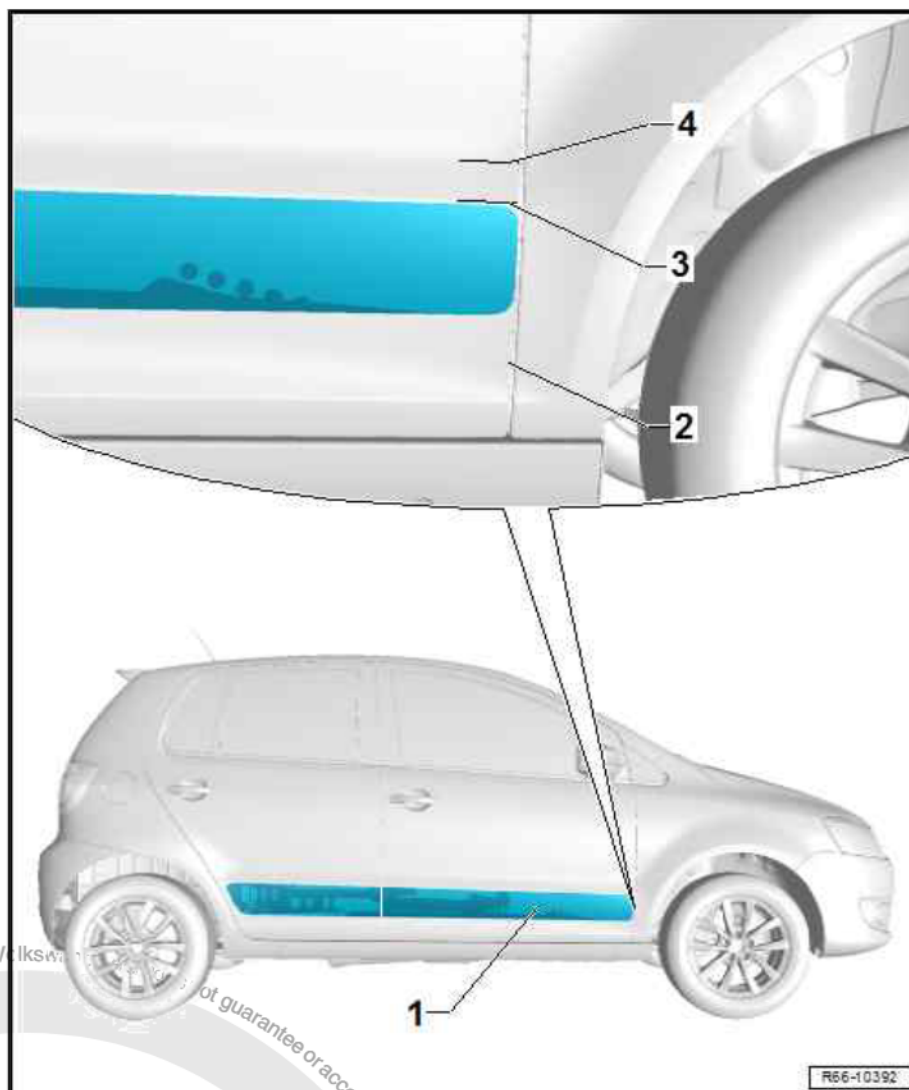
- ◆ Pressure roll - 3356-





1 - Front door fixed window

- ☐ Self-adherent
- ☐ Removal:
- ☐ Before removing, you must heat up the lining with the hot air blower - VAG 1416- .
- ☐ Installation:
- Clean the adhesion area with the cleaning solution - D 009 401 04- . Rub the surface with a cloth until it is completely dry.
- Upon installation, heat previously the adhesion area, with the Hot air blower - VAG 1416- .
- Remove the protective liner, position the plastic foil (mask) of the decorative stripe in relation to the door crease -3-, press carefully in order not to trap air bubbles under the stripe, and then, press strongly using the pressure roll - 3356- . Operating temperature approx. 20°C
- Remove the positioning mask from the decorative stripe.



2 - Door edge

- ☐ for positioning of decorative strip mask

3 - Lower crease of the door

- ☐ for positioning of decorative strip mask

4 - Upper crease of the door

4.28 Decorative strip on the rear door (Fox Rock in Rio MY 12 ►) - replace



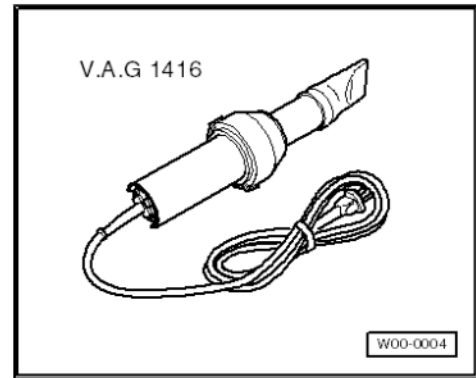
WARNING

- ◆ When handling chemicals follow the safety instructions → Chemical Products Manual; Rep. gr. 00
- ◆ Assignment of Chemical Materials → Electronic Parts Catalogue "ETKA"

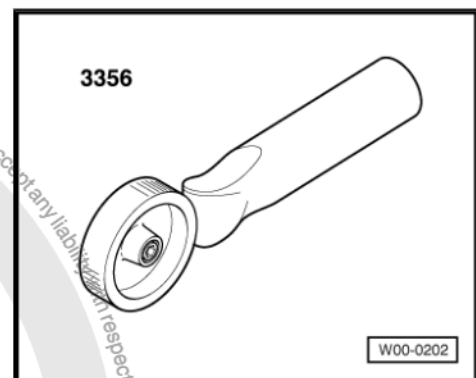
Special tools and workshop equipment required



◆ Hot air blower - VAG 1416-



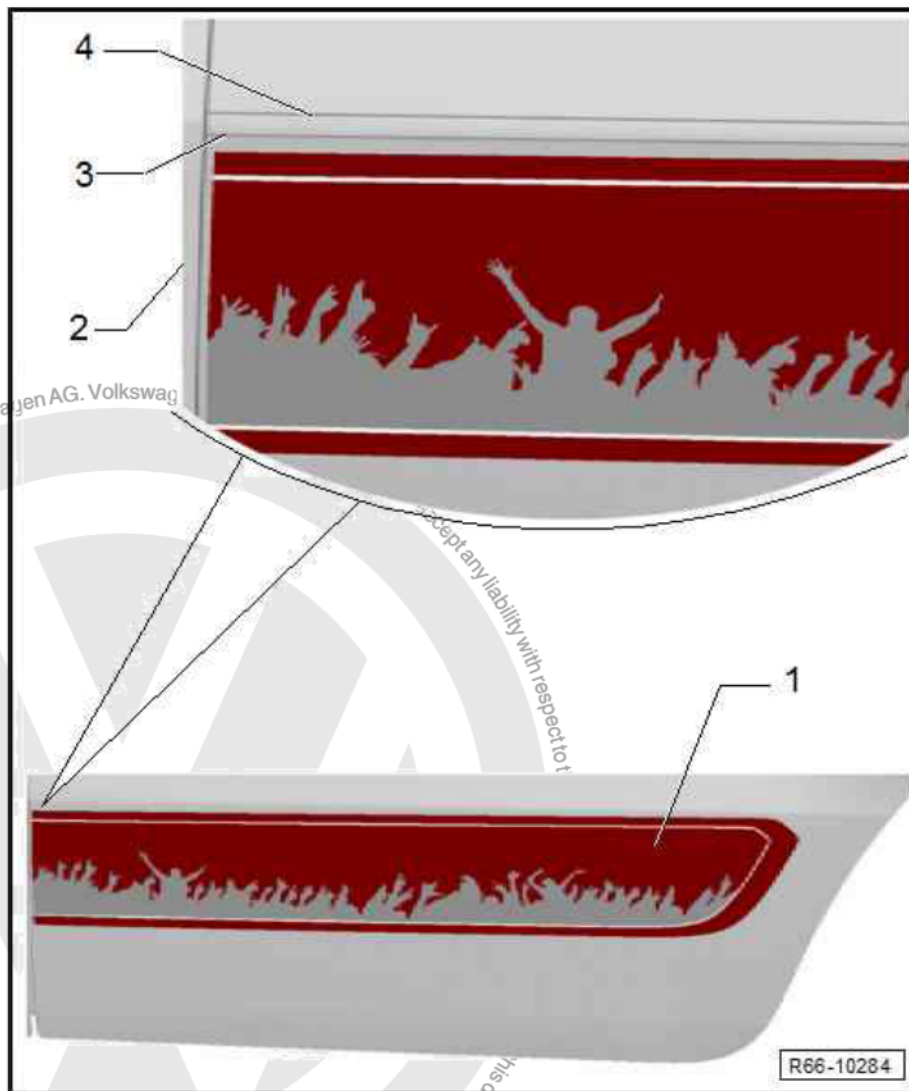
◆ Pressure roll - 3356-





1 - Rear door decorative stripe

- ☐ Self-adherent
- ☐ Before removing, you must heat up the lining with the hot air blower - VAG 1416- .
- ☐ When installing:
 - Clean the adhesion area with the cleaning solution - D 009 401 04- . Rub the surface with a cloth until it is completely dry.
 - Upon installation, heat previously the adhesion area for lining, with the Hot air blower - VAG 1416- .
 - Remove the covering liner, position the plastic foil (mask) of the covering in relation to the door crease -2-, press carefully in order not to trap air bubbles into the covering, and then, press strongly by using the pressure roll - 3356- . Operating temperature approx. 20°C
 - Remove the positioning mask from the decorative stripe.



2 - Front door edge

- ☐ for positioning of decorative strip mask

3 - Lower crease of the door

- ☐ for positioning of decorative strip mask

4 - Upper crease of the door

4.29 Decorative strip on the rear door (Fox Rock in Rio MY 14 ►) - replace



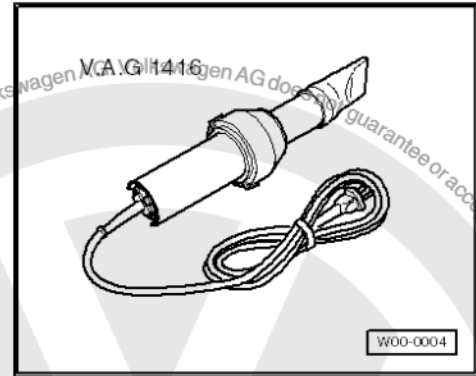
WARNING

- ◆ *When handling chemicals follow the safety instructions ⇒ Chemical Products Manual; Rep. gr. 00*
- ◆ *Assignment of Chemical Materials ⇒ Electronic Parts Catalogue "ETKA"*

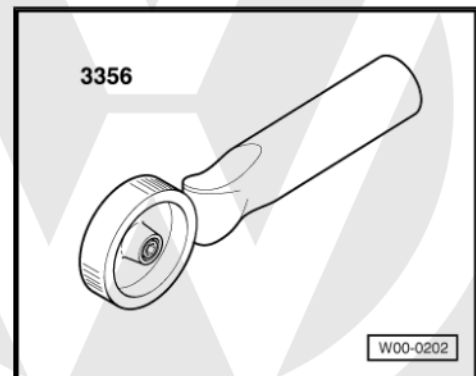
Special tools and workshop equipment required



◆ Hot air blower - VAG 1416-



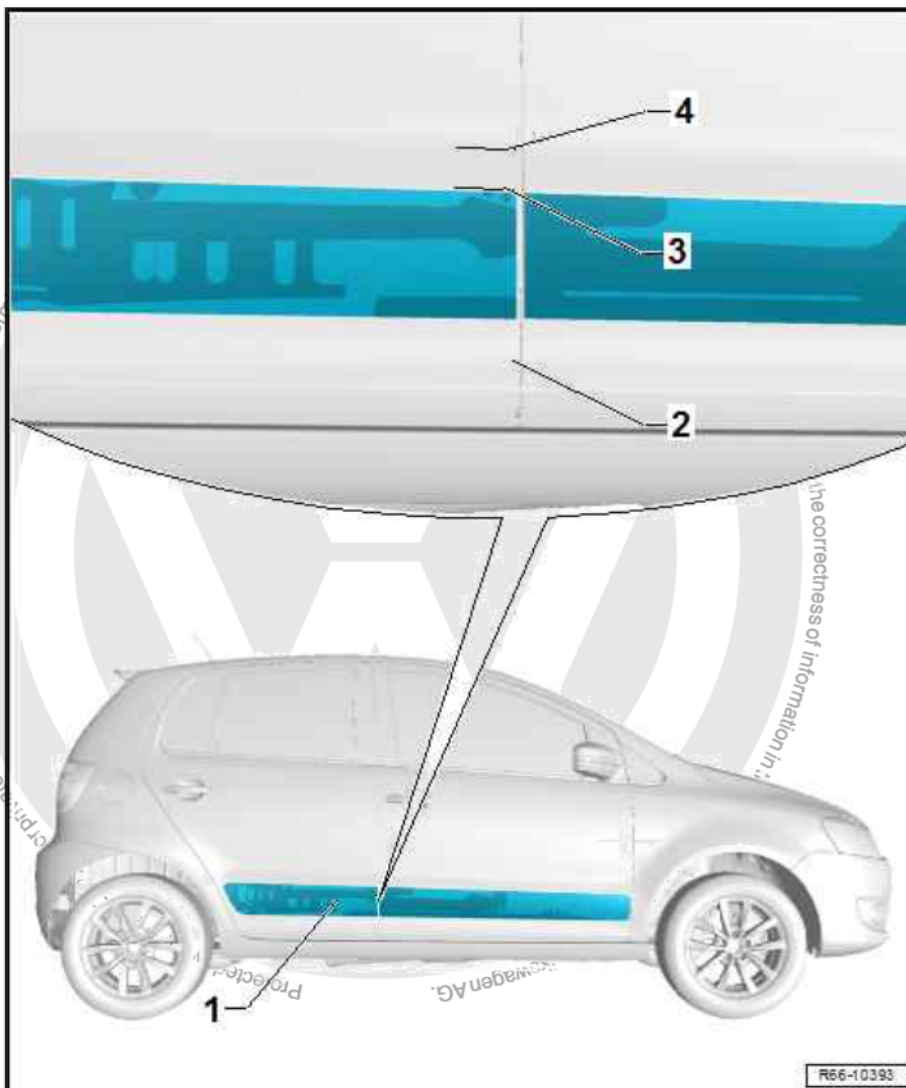
◆ Pressure roll - 3356-





1 - Rear door decorative stripe

- ☐ Self-adherent
- ☐ Removal:
- ☐ Before removing, you must heat up the lining with the hot air blower - VAG 1416- .
- ☐ Installation:
- Clean the adhesion area with the cleaning solution - D 009 401 04- . Rub the surface with a cloth until it is completely dry.
- Upon installation, heat previously the adhesion area, with the Hot air blower - VAG 1416- .
- Remove the covering liner, position the plastic foil (mask) of the covering in relation to the door crease -2-, press carefully in order not to trap air bubbles into the covering, and then, press strongly by using the pressure roll - 3356- . Operating temperature approx. 20°C
- Remove the positioning mask from the decorative stripe.



2 - Rear door edge

- ☐ for positioning of decorative strip mask

3 - Lower crease of the door

- ☐ for positioning of decorative strip mask

4 - Upper crease of the door

4.30 Decorative stripe on bumper rear protector (Fox) - replace



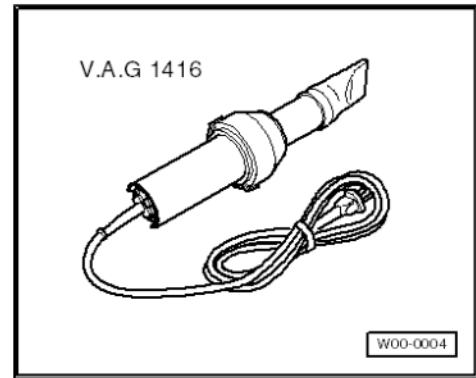
WARNING

- ◆ *When handling chemicals follow the safety instructions ⇒ Chemical Products Manual; Rep. gr. 00*
- ◆ *Assignment of Chemical Materials ⇒ Electronic Parts Catalogue "ETKA"*

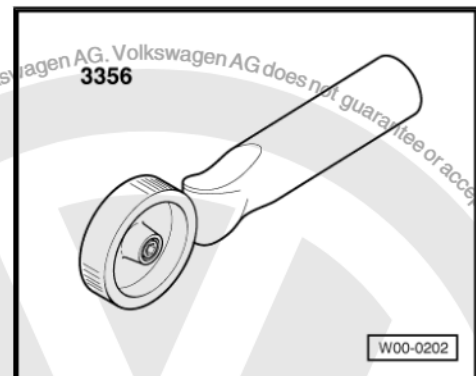
Special tools and workshop equipment required



◆ Hot air blower - VAG 1416-



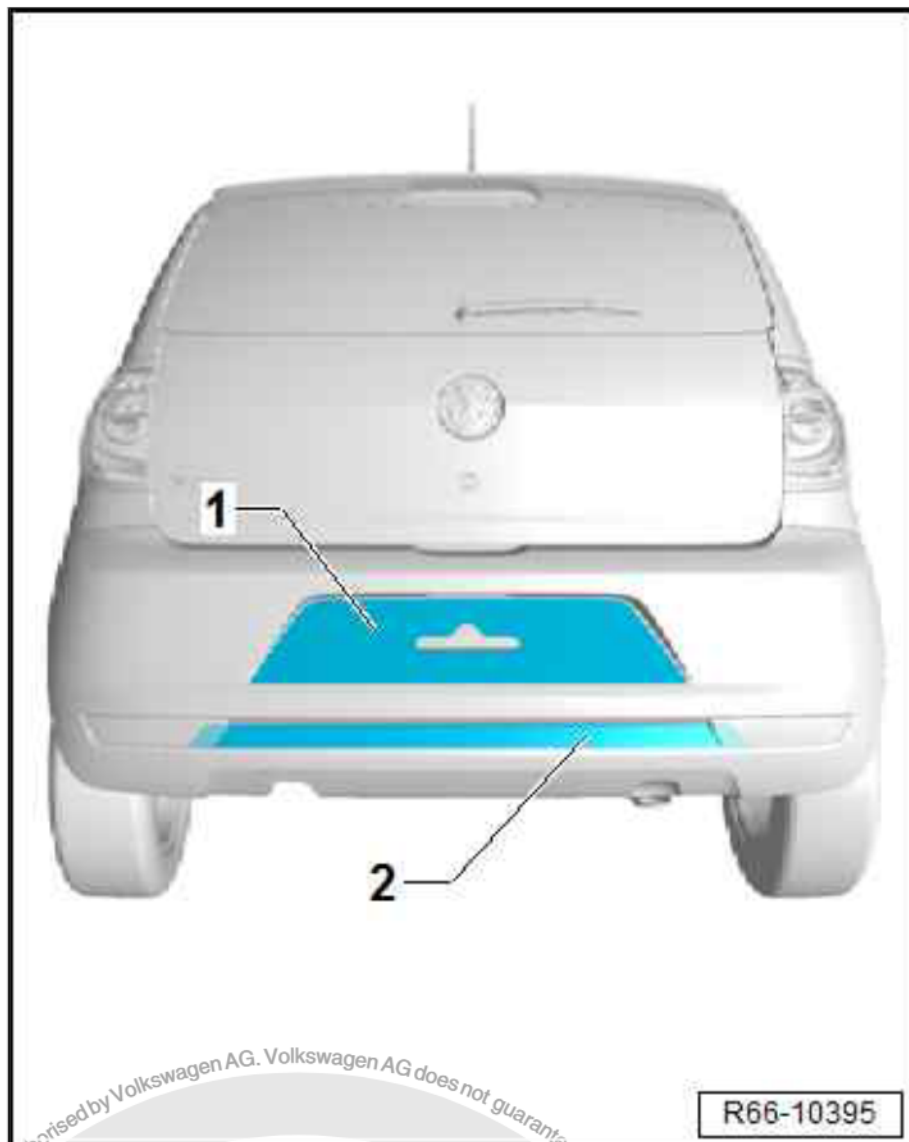
◆ Pressure roll - 3356-





1 - Upper decorative strip

- ☐ Self-adherent
- ☐ Removal:
 - ☐ Before removing, you must heat up the lining with the hot air blower - VAG 1416- .
- Detach rear protector decorative stripe -1- with a plastic spatula.
- Clean rear protector with adhesive remover - D 002 000 A2- and apply cleaning solution - D 009 401 04- . Rub the surface with a cloth until it is completely dry.
- ☐ Installation:
 - Remove the decorative strip liner and glue it as indicated. Use pressure roll - 3356-



2 - Lower decorative strip

- ☐ Self-adherent
- ☐ Removal:
 - ☐ Remove rearview mirrors (both sides) or the fog light (left side) ⇒ Electrical equipment; Rep. gr. 94 ; External lamps, lights and switches .
 - ☐ Before removing, you must heat up the lining with the hot air blower - VAG 1416- .
- Detach rear protector decorative stripe -2- with a plastic spatula.
- Clean rear protector with adhesive remover - D 002 000 A2- and apply cleaning solution - D 009 401 04- . Rub the surface with a cloth until it is completely dry.
- ☐ Installation:
 - Remove the decorative strip liner and glue it as indicated. Use pressure roll - 3356-

4.31 Side badge (Crossfox) - replace



WARNING

- ◆ *When handling chemicals follow the safety instructions ⇒ Chemical Products Manual; Rep. gr. 00*
- ◆ *Assignment of Chemical Materials ⇒ Electronic Parts Catalogue "ETKA"*



1 - Rear passenger door badge gluing area

- ❑ Clean the area using adhesive remover - D 002 000 A2- , then apply the cleaning solution - D 009 401 04- .

2 - Rear door badge

- ❑ Self-adherent
- ❑ Rear bumper central protection
- ❑ Heat badge using the hot air blower - VAG 1416- prior to removal.
- ❑ Remove badge liner, place the badge plastic foil in relation to the door crease -a-, carefully press in order not to trap air bubbles into the badge, then press it strongly using the pressure roll - 3356- . Operating temperature approx. 20°C.

a = 1 mm from curvature radius

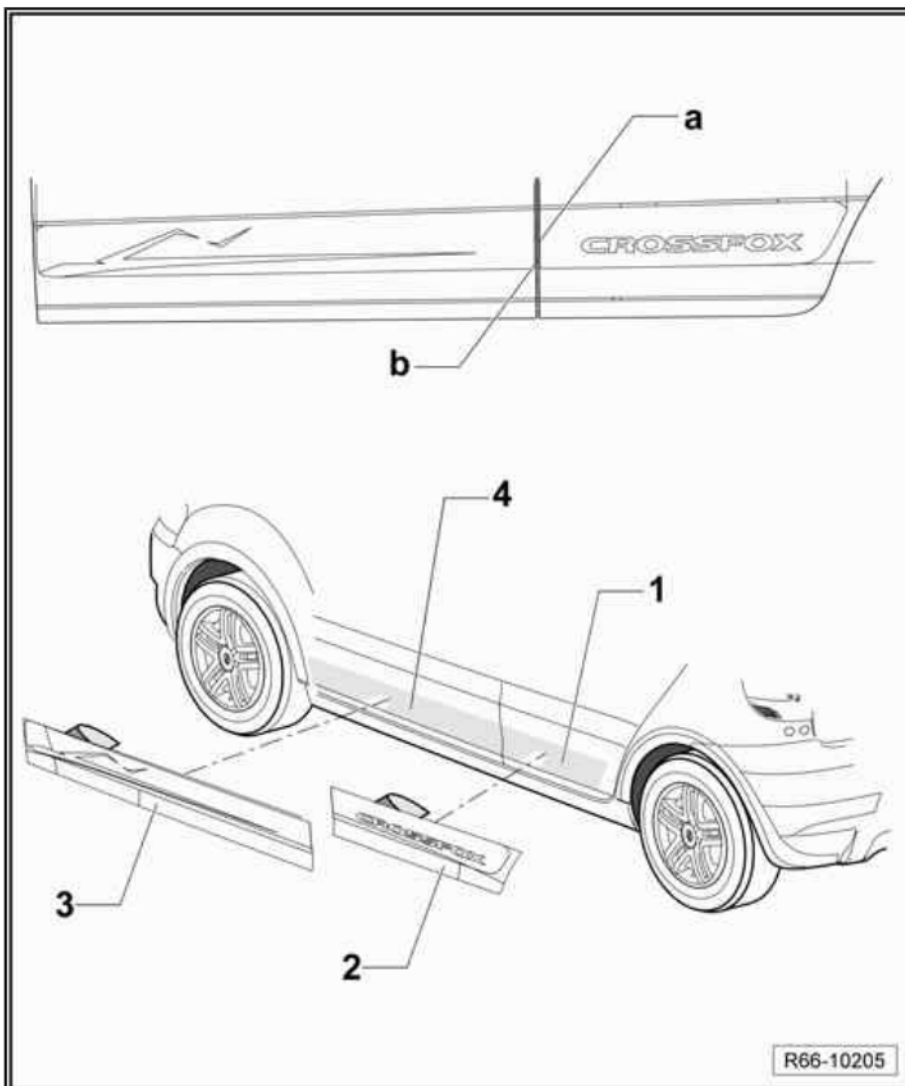
3 - Front door badge

- ❑ Self-adherent
- ❑ Heat badge using the hot air blower - VAG 1416- prior to removal.
- ❑ Remove badge liner, place the badge plastic foil in relation to the door crease -b-, carefully press in order not to trap air bubbles into the badge, then press it strongly using the pressure roll - 3356- . Operating temperature approx. 20°C.

b = 1 mm from curvature radius

4 - Front door badge gluing area

- ❑ Clean the area using adhesive remover - D 002 000 A2- , then apply the cleaning solution - D 009 401 04- .



4.32 Badge of the "Rock in Rio" version on the ashtray (Gol Rock in Rio MY 14 ►) - replace

Removal:



Note

Before removal, you must carefully heat up the badge with the hot air blower - VAG 1416- .

- Detach the badge with a plastic scraper.



- Clean the ashtray with adhesive remover - D 002 000 A2- and apply cleaning solution - D 009 401 04- . Scrub the surface with a cloth until it is completely dry.

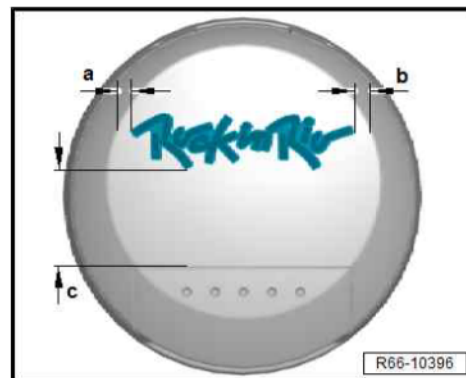
Installation:

- Remove badge liner and glue it as indicated. Use pressure roll - 3356-

a = 3.5 mm

b = 3.4 mm

c = 18.6 mm

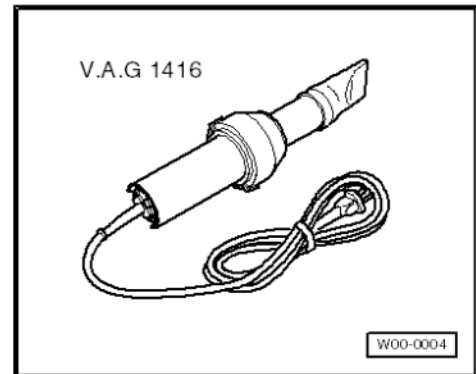




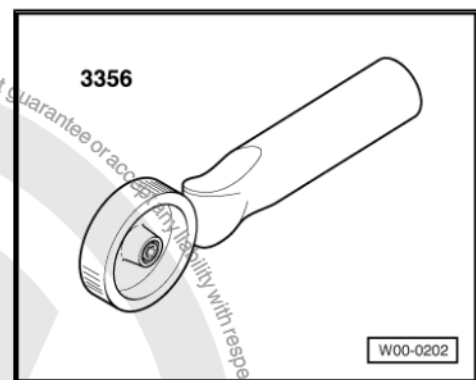
5 Side footboard (Crossfox)

Special tools and workshop equipment required

- ♦ Hot air blower - VAG 1416-



- ♦ Pressure roll - 3356-



5.1 Rear side panel trim (Crossfox and Space Cross / Suran Cross) - replace



WARNING

- ♦ *When handling chemicals follow the safety instructions ⇒ Chemical Products Manual; Rep. gr. 00*
- ♦ *Assignment of Chemical Materials ⇒ Electronic Parts Catalogue "ETKA"*



1 - Rear side panel trim

- ☐ Self-adherent
- ☐ Before removing, you must heat up the lining with the hot air blower - VAG 1416- .
- ☐ Clean the area using adhesive remover - D 002 000 A2- , then apply the cleaning solution - D 009 401 04- .
- ☐ Remove the adhesive tape liner, position the trim. Operating temperature approx. 20°C.

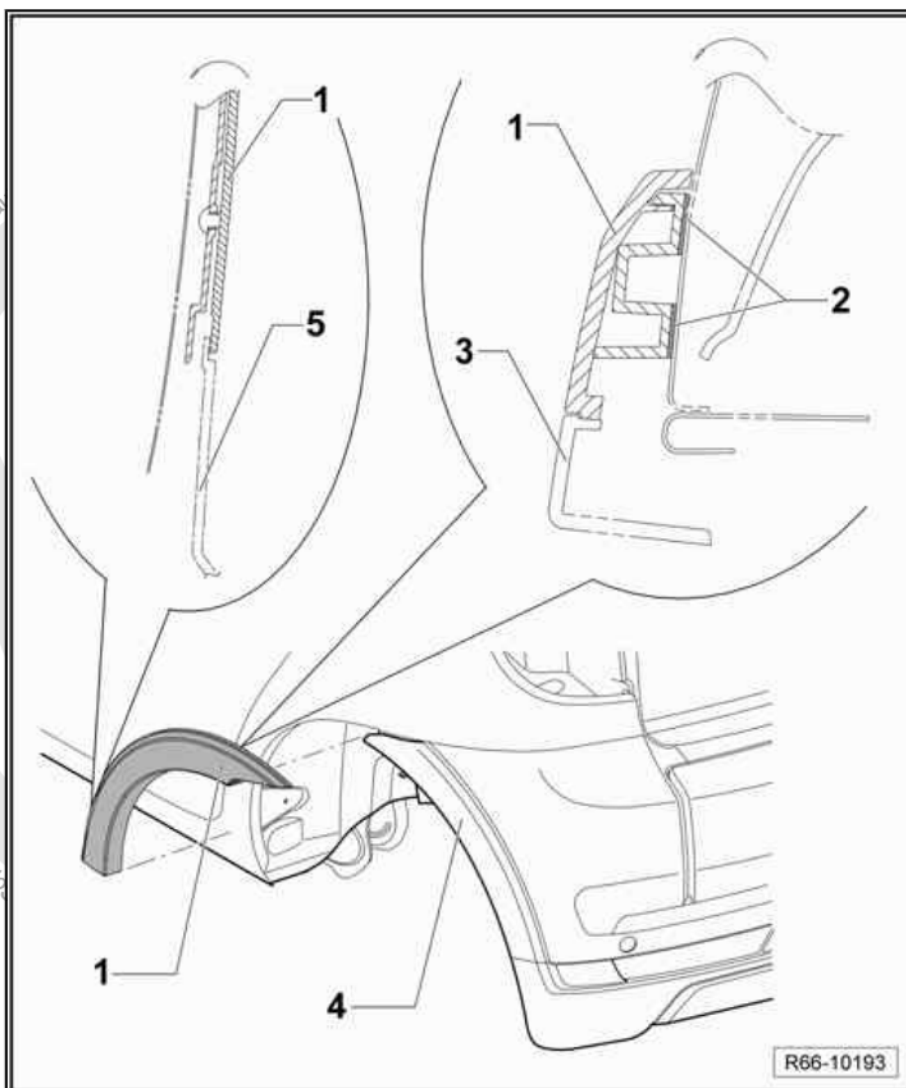
2 - Double-sided adhesive tape

- ☐ The adhesive tape adhesion area must be completely free of dirt.
- ☐ Under no circumstances should the self-adhesive surface of the tape be touched.

3 - Rear bumper protector

4 - Remove bumper rear protector

5 - Side footboard rear lining





5.2 Front wing trim (Crossfox and Space Cross / Suran Cross) - replace

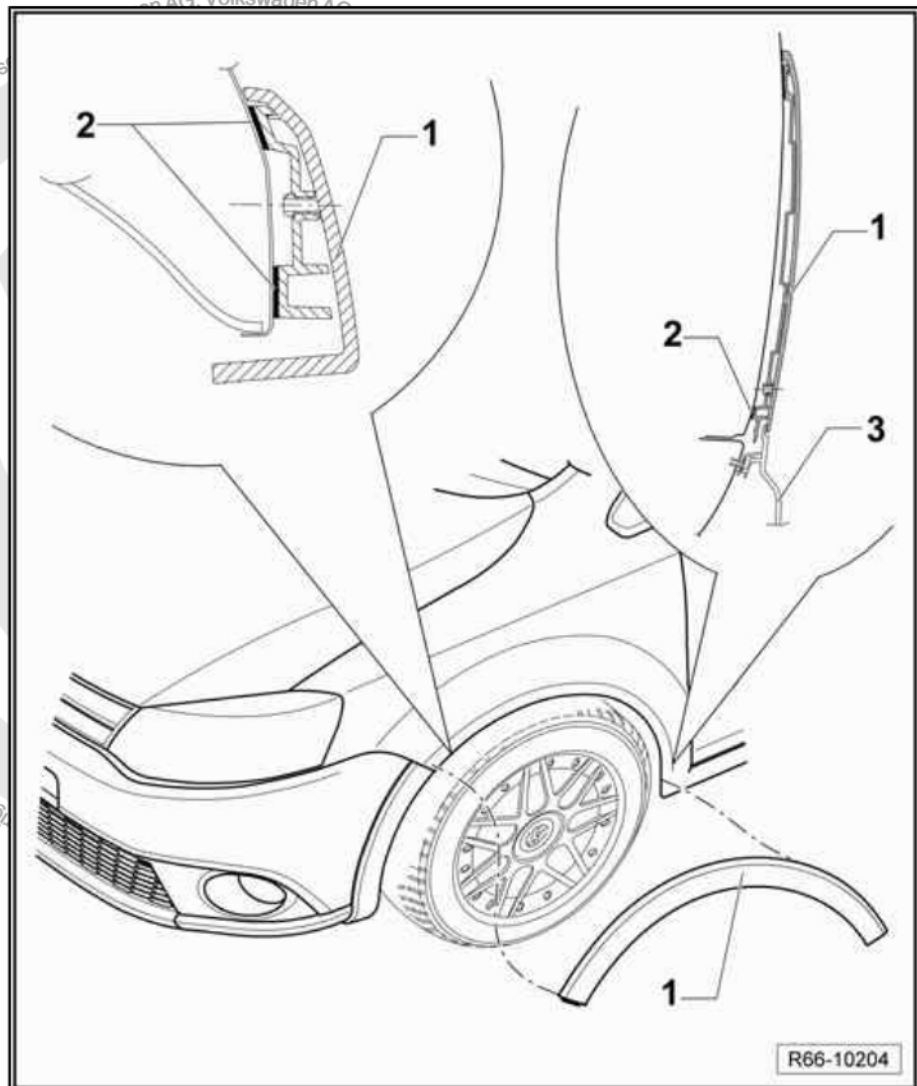
1 - Front wing trim

- ☐ Self-adherent
- ☐ Before removing, you must heat up the trim with the hot air blower - VAG 1416- .
- ☐ Clean the area using adhesive remover - D 002 000 A2- , then apply the cleaning solution - D 009 401 04- .
- ☐ Remove the adhesive tape liner, position the trim. Operating temperature approx. 20°C.

2 - Double-sided adhesive tape

- ☐ The adhesive tape adhesion area must be completely free of dirt.
- ☐ Under no circumstances should the self-adhesive surface of the tape be touched.

3 - Side footboard (lining)





5.3 Side footboard (CrossFox and Space Cross / Suran Cross)- Assembly overview

1 - Side footboard

- ☐ Side footboard and lining are removed together
- ☐ Remove and install
⇒ [page 225](#)

2 - Bolt

- ☐ Torque: 6 Nm

3 - Pop rivet nut

- ☐ To install, use the POP NUT rivet nut applicator
- VAG 1765B- or POP NUT rivet nut applicator
- EQ 7422-

4 - Nut

- ☐ Torque: 6 Nm

5 - Bolt

6 - Double-sided adhesive tape

- ☐ The adhesive tape adhesion area must be completely free of dirt.
- ☐ Under no circumstances should the self-adhesive surface of the tape be touched.

7 - Bushing

8 - Fastening pin

9 - Front wing trim

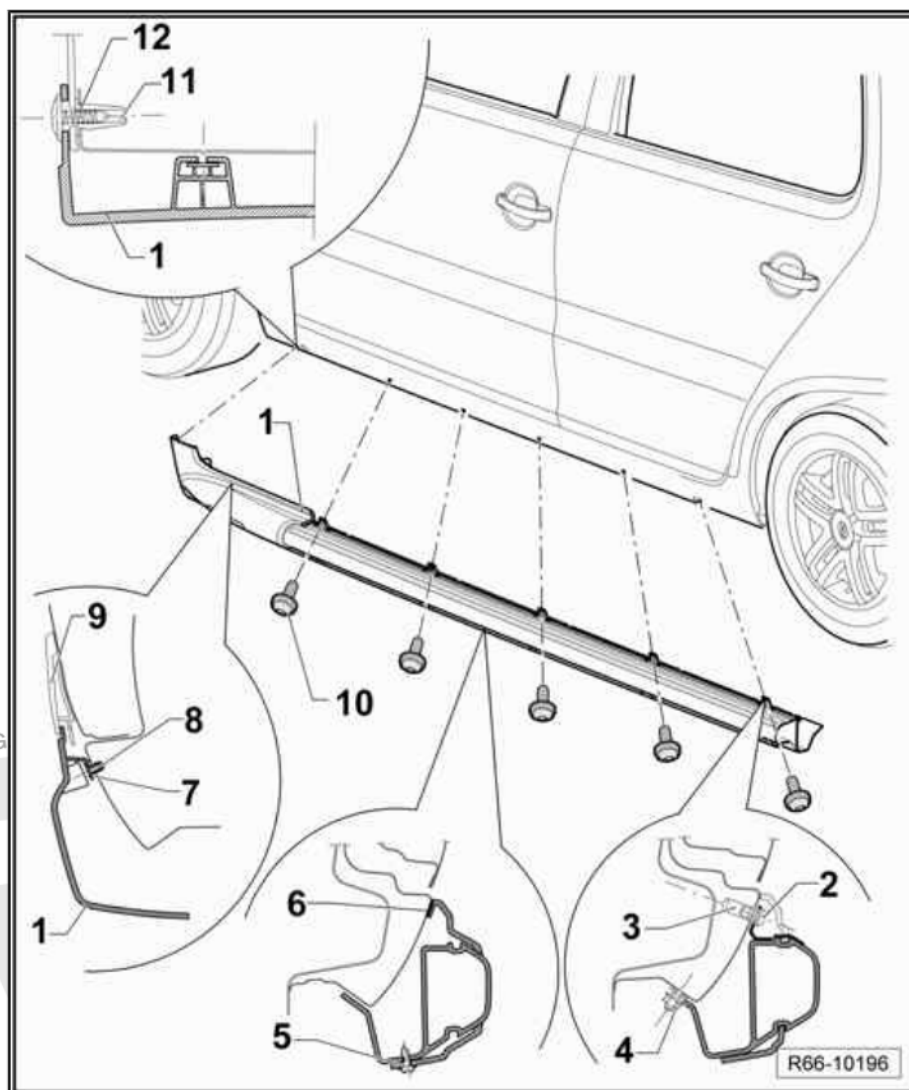
10 - Bolt

- ☐ Torque: 6 Nm

11 - Bushing

12 - Bolt

- ☐ Torque: 1.5 Nm



5.4 Side footboard (CrossFox and Space Cross / Suran Cross) - Assembly overview - continued



WARNING

- ◆ When handling chemicals follow the safety instructions ⇒ Chemical Products Manual; Rep. gr. 00
- ◆ Assignment of Chemical Materials ⇒ Electronic Parts Catalogue "ETKA"



1 - Pop rivet nut

- ☐ To install, use the POP NUT rivet nut applicator - VAG 1765B- or POP NUT rivet nut applicator - EQ 7422-

2 - Bolt

- ☐ Torque: 6 Nm

3 - Lock pin

4 - Footboard lining

- ☐ Self-adhesive and fastened by screws -4-.
- ☐ If footboard is removed, lining must be replaced.
- ☐ Before removing, you must heat up the lining with the hot air blower - VAG 1416- .
- ☐ Clean the area where lining shall be glued with adhesive remover - D 002 000 A2- , then apply the cleaning solution - D 009 401 04- .
- ☐ Operating temperature approx. 20°C.

5 - Bolt

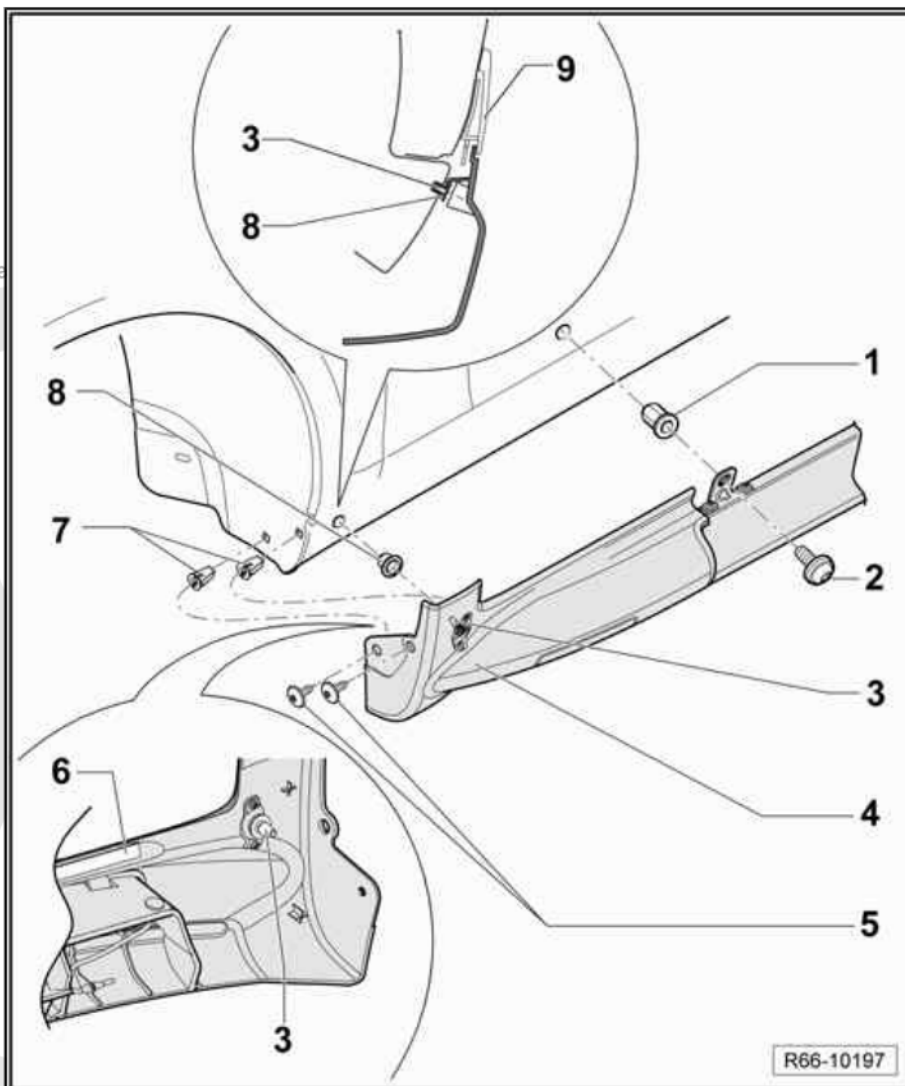
- ☐ Torque: 1.5 Nm

6 - Double-sided adhesive tape

- ☐ The adhesive tape adhesion area must be completely free of dirt.
- ☐ Under no circumstances should the self-adhesive surface of the tape be touched.

7 - Bushing

8 - Bushing



5.5 Side footboard (Crossfox) - replace

5.5.1 Removal



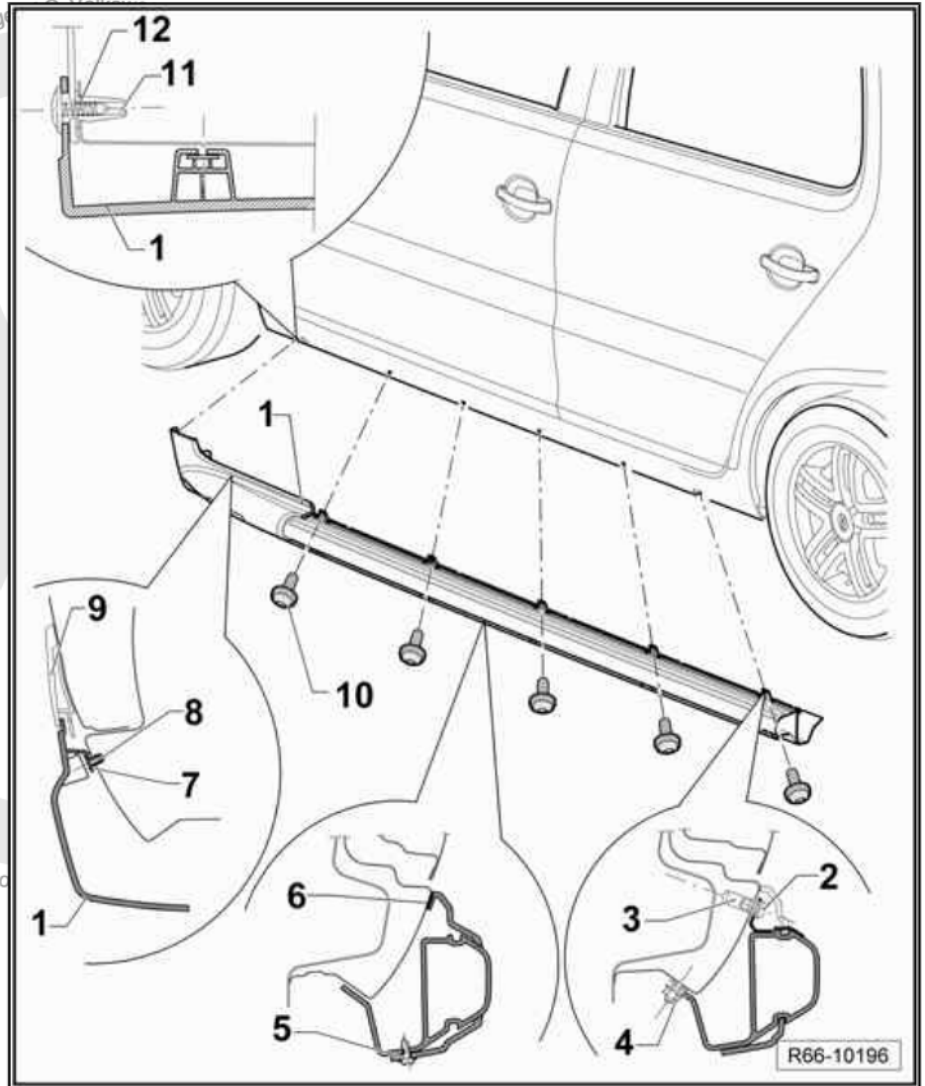
WARNING

- ◆ When handling chemicals follow the safety instructions ⇒ Chemical Products Manual; Rep. gr. 00
- ◆ Assignment of Chemical Materials ⇒ Electronic Parts Catalogue "ETKA"

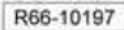
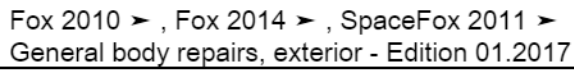
- Remove footboard rear lining ⇒ [page 231](#) .



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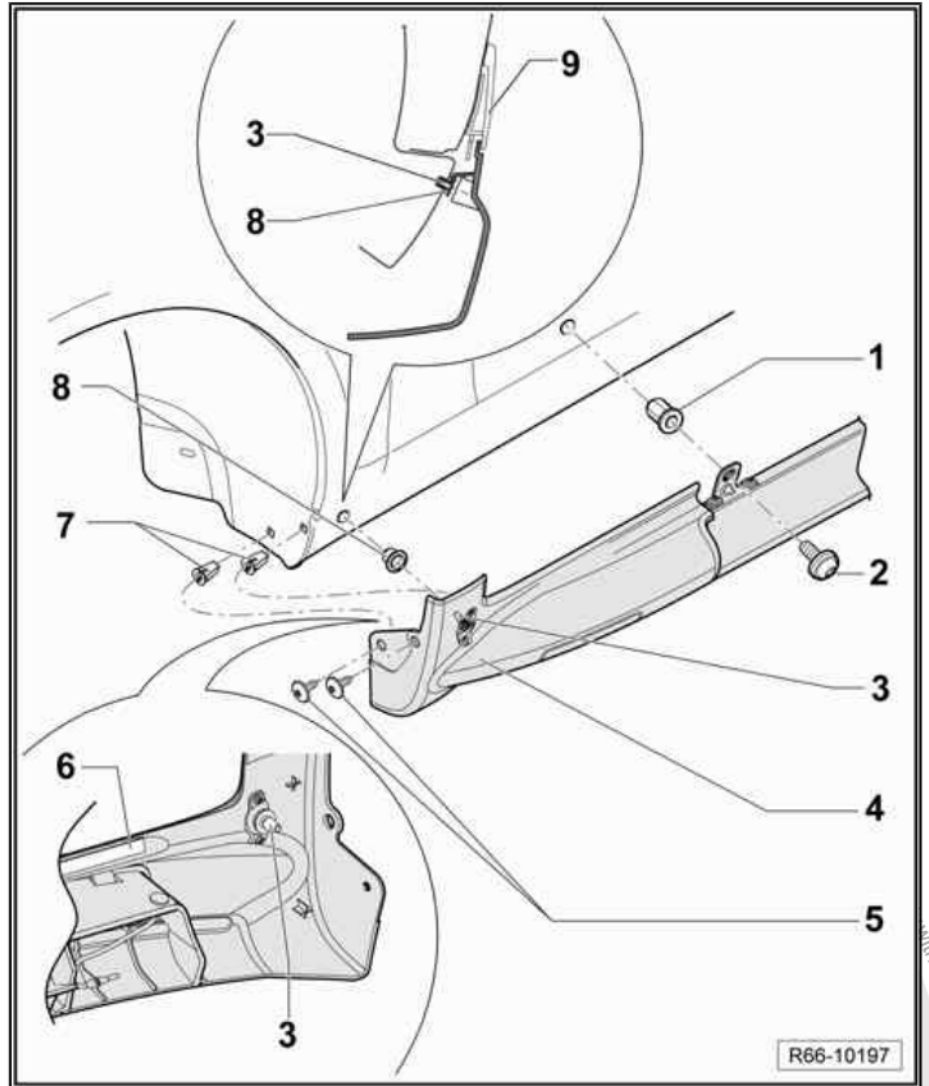


- Remove side footboard upper lining ➤ [page 232](#) .
- Remove nuts -4- and screws -10-. An assistant must keep the footboard suspended until its removal.

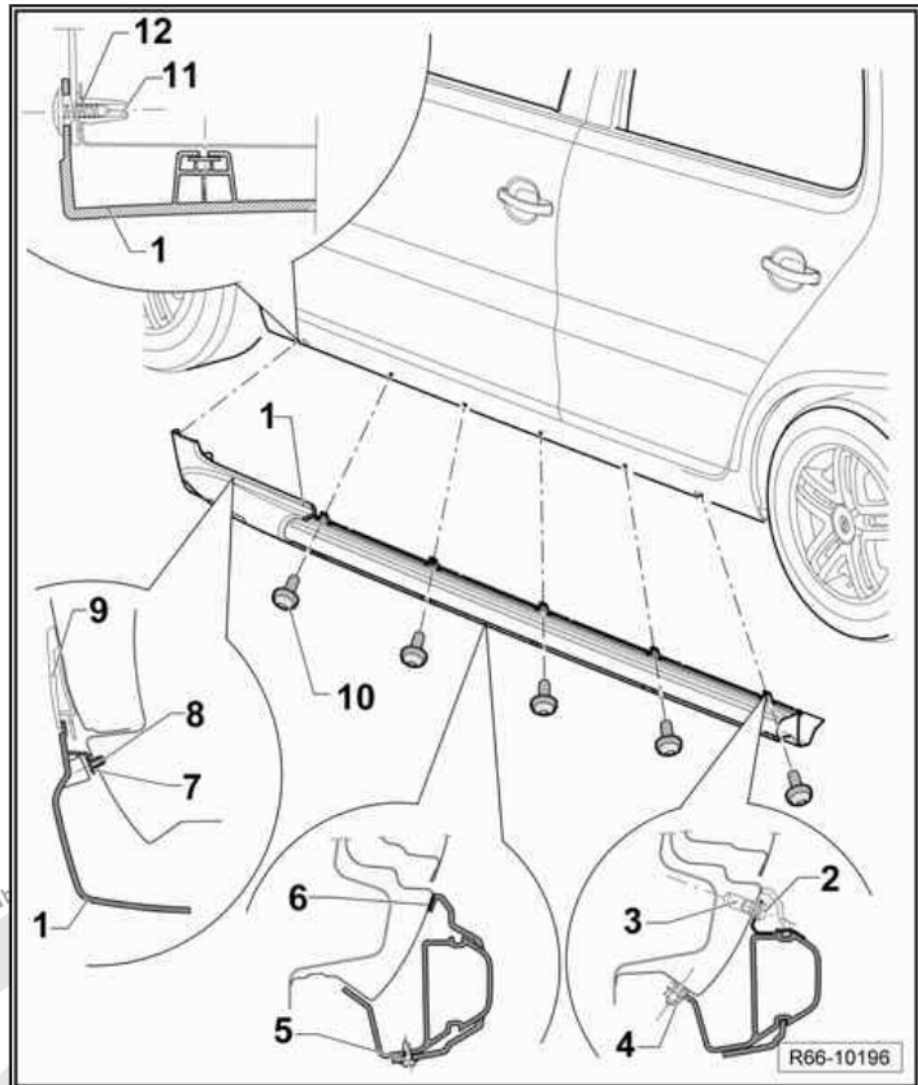


- ### 5.5.2 Installation

- 228 Rep. gr.66 - Exterior equipment



- Heat footboard lining -4- with the hot air blower - VAG 1416- .
- Position footboard and install screw -2-.
- Install the screws -5-.



- Install nuts -4- and screws -8-.
- Heat footboard upper lining -3- with the hot air blower - VAG 1416-
- Press footboard upper lining against body with a pressure roll - 3356-
- Install footboard rear lining ➔ [page 231](#) .



5.6 Side footboard rear lining (CrossFox and Space Cross / Suran Cross) - assembly overview

1 - Side footboard rear lining

- ☐ Replace ⇒ [page 231](#)

2 - Nut

- ☐ Torque: 6 Nm

3 - Double-sided adhesive tape

- ☐ The adhesive tape adhesion area must be completely free of dirt.
- ☐ Under no circumstances should the self-adhesive surface of the tape be touched.

4 - Fastening clip

5 - Pressure clamp

6 - Lock pin

7 - Bolt

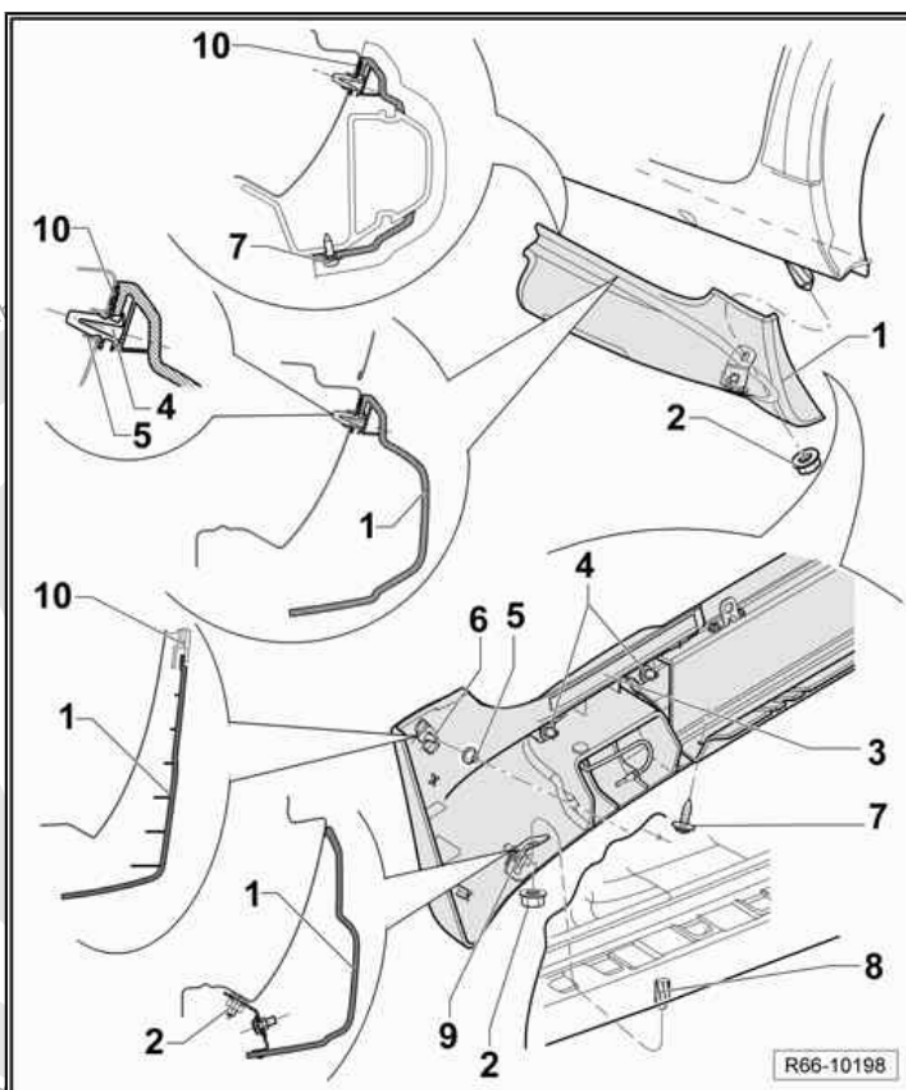
- ☐ Torque: 3 Nm

8 - Stud

9 - Lining support

- ☐ riveted to lining

10 - Rear side panel trim



5.7 Rear footboard lining (Crossfox and Space Cross / Suran Cross) - replace

Removal:

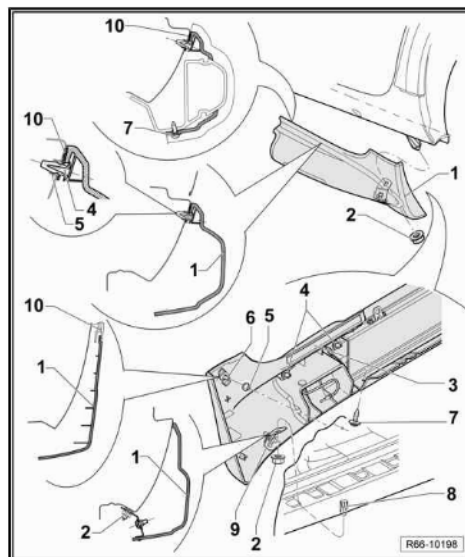
- Remove screw -7- and nut -2-.



- Detach side footboard rear lining -1- by heating it up with the hot air blower - VAG 1416- .

Installation:

- Clean the area where footboard rear lining shall be glued on body with adhesive remover - D 002 000 A2- and then apply the cleaning solution - D 009 401 04- .
- Heat up the footboard rear lining -1- with the hot air blower - VAG 1416- .
- Place rear lining and install screw -7- and nut -2-.
- Press footboard rear lining against body with a pressure roll - 3356- .



5.8 Upper footboard lining (Crossfox and Space Cross / Suran Cross) - replace

1 - Side footboard upper lining

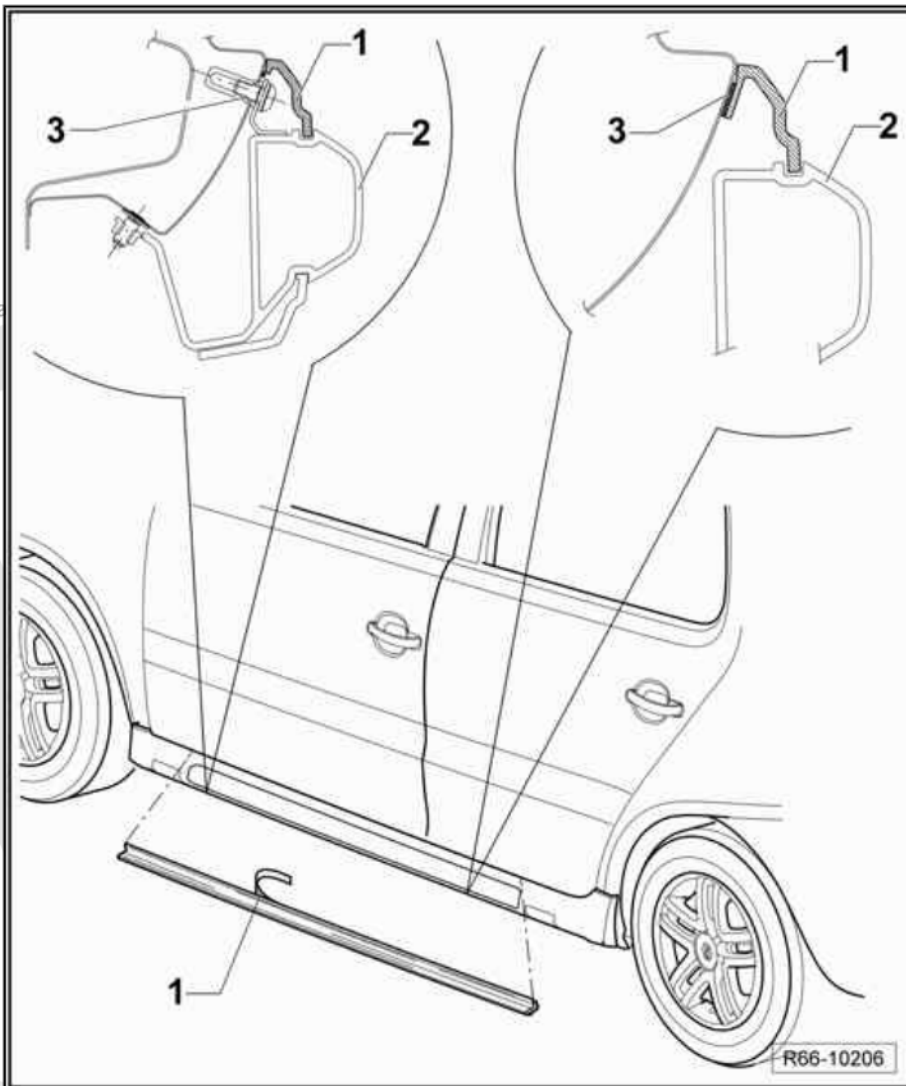
- ☐ Before removing, you must heat up the lining with the hot air blower - VAG 1416- .
- ☐ Clean the area where lining shall be glued with adhesive remover - D 002 000 A2- , then apply the cleaning solution - D 009 401 04- .
- ☐ Operating temperature approx. 20°C.

2 - Side footboard

- ☐ Replace ⇒ [page 226](#)

3 - Double-sided adhesive tape

- ☐ The adhesive tape adhesion area must be completely free of dirt.
- ☐ Under no circumstances should the self-adhesive surface of the tape be touched.





6 External rear-view mirror

6.1 External rear-view mirror - assembly overview

1 - Internal control

2 - Bolt

- ☐ 3 units
- ☐ Torque: 2.5 Nm

3 - Nut

- ☐ 1 unit
- ☐ Torque: 2.0 Nm

4 - Command fastening support

- ☐ version with manual command

5 - Bushing

6 - Mirror glass

- ☐ fitted in for both versions (manual and electric command)
- ☐ Remove and install
⇒ [page 235](#)

7 - Bushing

8 - Harness connector for electric rear-view mirror

9 - Pop rivet

- ☐ 2 units
- ☐ version with manual command

10 - Clip

11 - Mirror fastening cover

- ☐ version with manual command

12 - Operating button

- ☐ version with manual command
- ☐ fitted in to command activation rod

13 - Bolt

14 - Mirror fastening cover

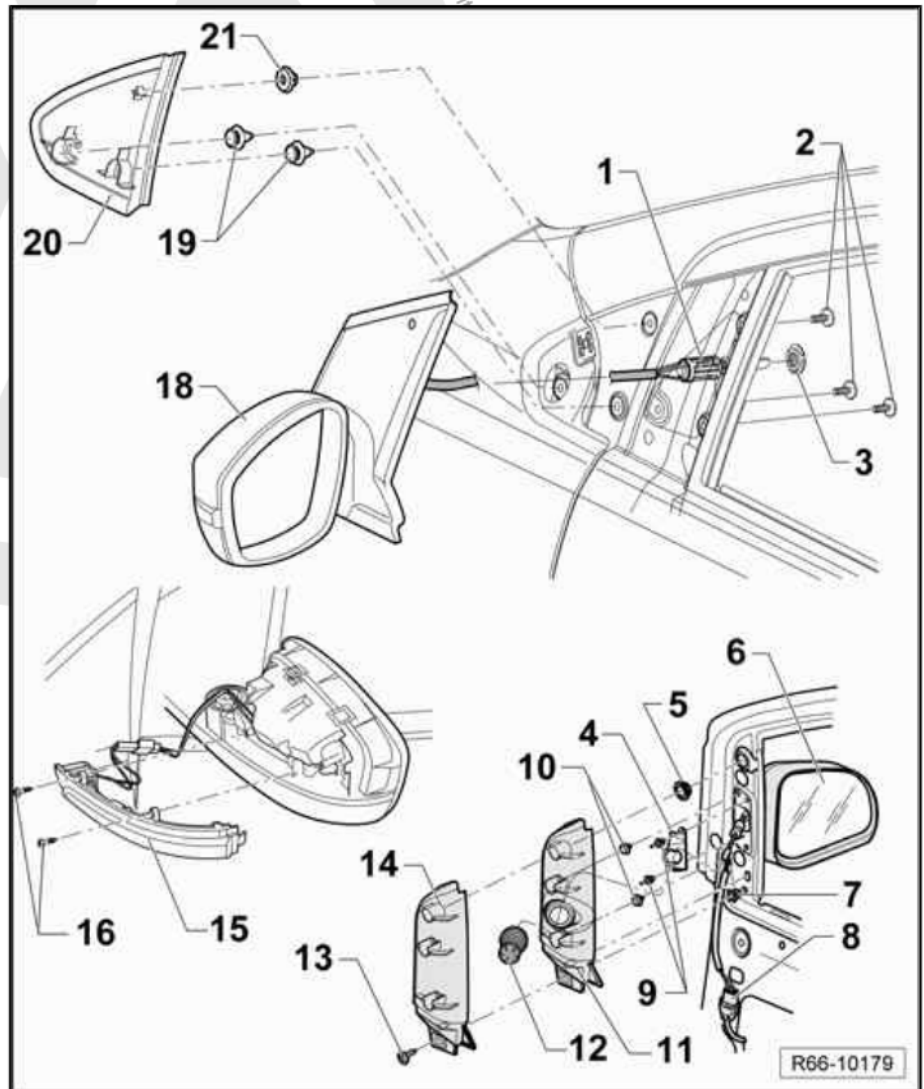
- ☐ version with electric command

15 - Direction indicator light

- ☐ remove mirror covering -18- to access the fastening.

16 - Bolt

- ☐ 2 units
- ☐ Torque: 1.5 Nm





- 17 - Direction indicator light harness connector
- 18 - Mirror covering
- 19 - Clip
- 20 - Finishing cover
- 21 - Bushing

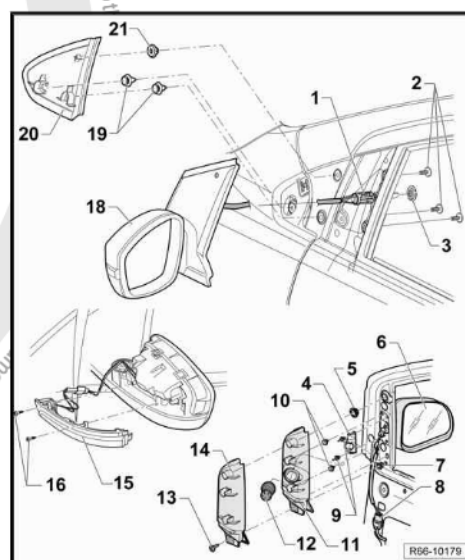
6.2 Exterior rear-view mirror - remove and install

Removal:

- Remove the door lining ⇒ General body repairs, interior; Rep. gr. 70 : Lining / insulation
- Remove cover cap (with manual command) -14- or (with electric command) -17-.
- ♦ For version with manual command, remove activation button -12- and remove nut -11-.
- ♦ For version with electric command, disconnect connector -8-.
- Remove screws -2- and remove the external rear-view mirror.

Installation:

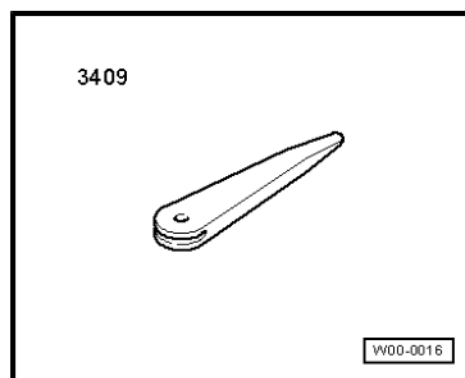
- Installation is performed in the reverse sequence to the removal.



6.3 Mirror covering - remove

Special tools and workshop equipment required

- ♦ Wedge - 3409-





Removal:

- Insert wedge - 3409- between the rear-view mirror case and cover and initially unlock the retainer lock -1-; then unlock the retainer locks -2-.

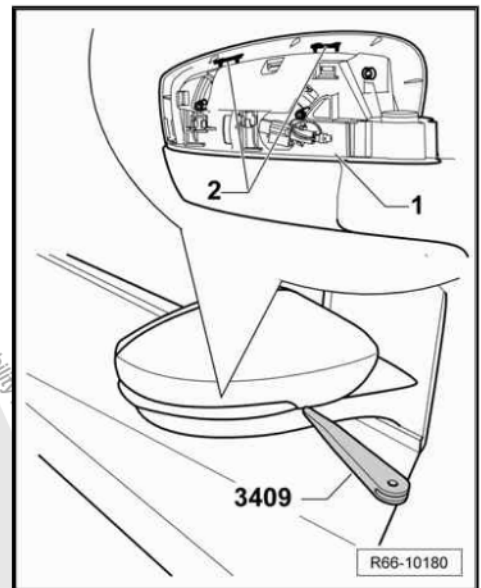


Caution

The cover is made of PA6 + 30 % and the mirror frame is made of ASA (Styrol Acrylnitril modified by Acrilester). Therefore, they are sensitive to locking pawl breakages.

Installation:

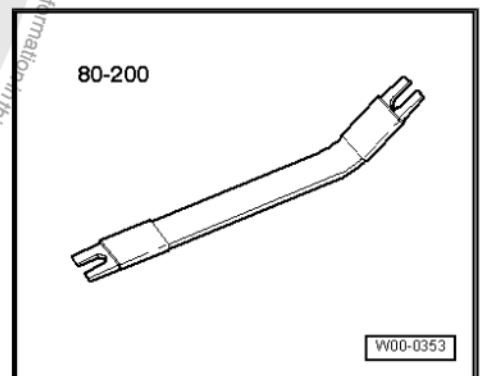
- Press the covering and first fit it to the upper section of the case, and then to the lower section.



6.4 Mirror glass - remove and install

Special tools and workshop equipment required

- ◆ Removal lever - 80-200-



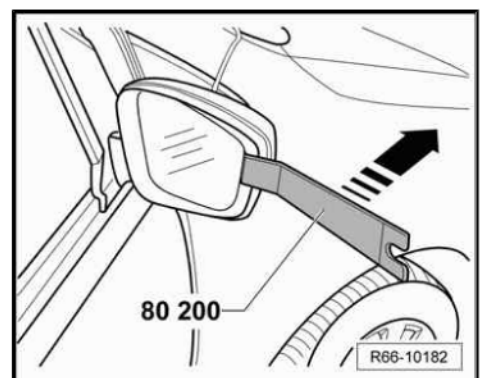
Removal:

- Place mirror glass -2- facing the mirror case interior. Insert a removal lever - 80-200- through the opening between mirror glass and case.
- Carefully move removal lever - 80-200- towards the -arrow- and disengage mirror glass.



Note

Protect mirror case with masking tape.



Installation:

- Press mirror glass center to fit it.



DANGER!

Press only onto the glass centre. Always wear safety gloves.



7 Side trims

7.1 Side trims (Fox - 2-door) - replace

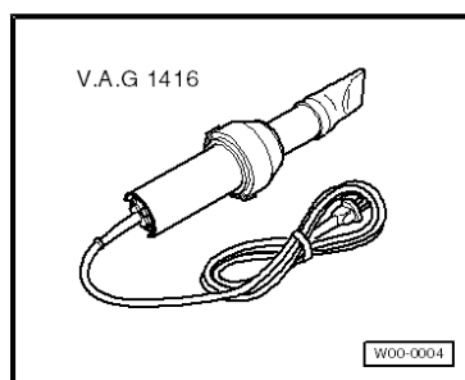


WARNING

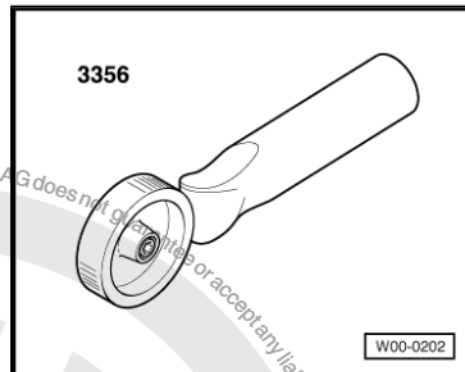
- ◆ *When handling chemicals follow the safety instructions ⇒ Chemical Products Manual; Rep. gr. 00*
- ◆ *Assignment of Chemical Materials ⇒ Electronic Parts Catalogue "ETKA"*

Special tools and workshop equipment required

- ◆ Hot air blower - VAG 1416-



- ◆ Pressure roll - 3356-



Side trims:



1 - Trim adhesion area

- ☐ Clean the area using adhesive remover - D 002 000 A2- , then apply the cleaning solution - D 009 401 04- .

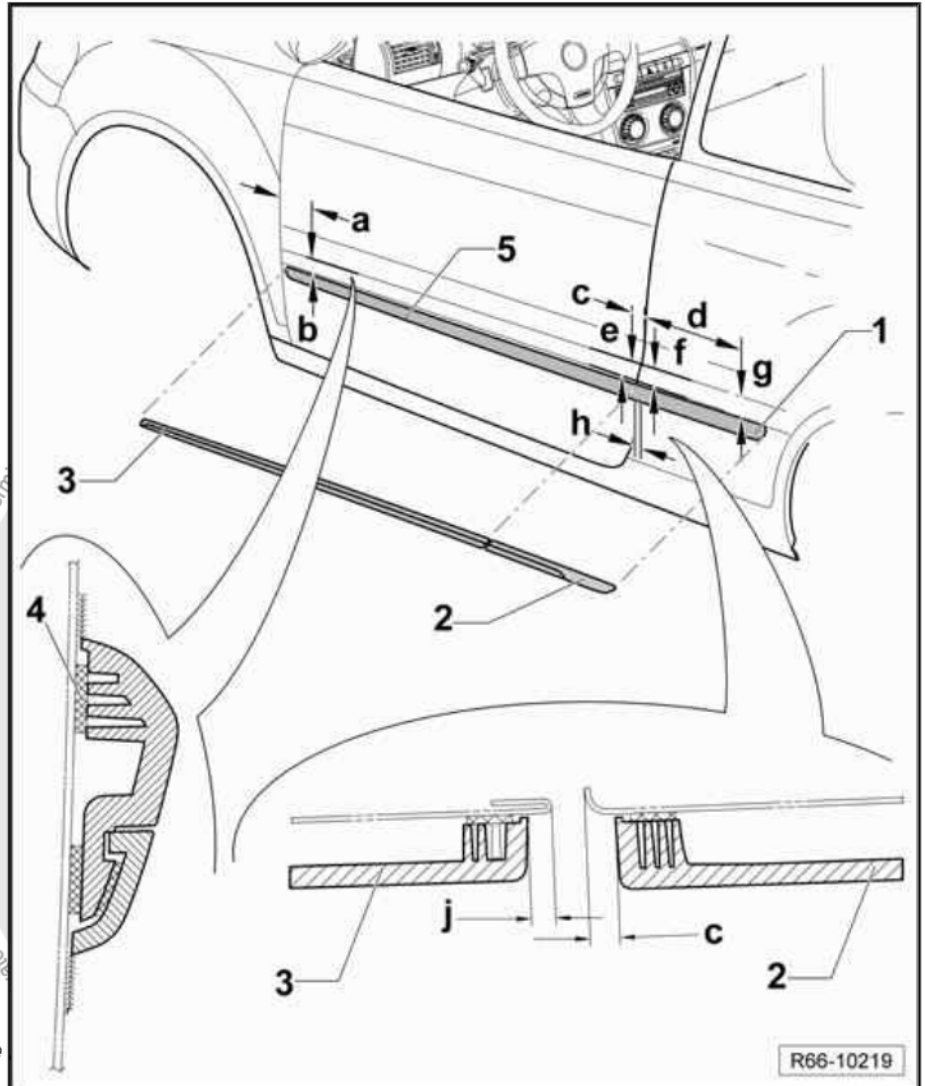
2 - Rear side lining

- ☐ Self-adherent
- ☐ Remove
 - Unglue the trim with the hot air blower - VAG 1416- , for easing the removal.
 - Remove all dirt and oiliness.
 - Remove adhesive residues with the adhesive remover - D 002 000 A2- and apply the cleaning solution - D 009 401 04- . Rub the surface with a cloth until it is completely dry.
- ☐ Install
 - Heat up trim and surface with hot air blower - VAG 1416- to make installation easier.
 - Remove the liner from the double-sided adhesive tape, position the trim and press with the pressure roll - 3356- .



Note

Operating temperature
C.



- ◆ c = 4.3 mm
- ◆ d = 398 mm
- ◆ f = 7.4 mm
- ◆ g = 8.2 mm
- ◆ h = 2.0 mm

3 - Front door trim

- ☐ Self-adherent
- ☐ Remove
 - Unglue the trim with the hot air blower - VAG 1416- , for easing the removal.
 - Remove all dirt and oiliness.
 - Remove adhesive residues with adhesive remover - D 002 000 A2- and apply cleaning solution - D 009 401 04- . Rub the surface with a cloth until it is completely dry.
- ☐ Install
 - Heat up trim and surface with hot air blower - VAG 1416- to make installation easier.
 - Remove the liner from the double-sided adhesive tape, position the trim and press with the pressure roll - 3356- .



Note

Operating temperature approx. 20°
C.



- ◆ a = 177 mm
- ◆ b = 5.4 mm
- ◆ c = 4.3 mm
- ◆ e = 7.3 mm
- ◆ j = 2.5 mm
- 4 - Double-sided adhesive tape
 - ❑ The adhesive tape adhesion area must be completely free of dirt.
 - ❑ Under no circumstances should the self-adhesive surface of the tape be touched.
- 5 - Trim adhesion area
 - ❑ Clean the area using adhesive remover - D 002 000 A2- , then apply the cleaning solution - D 009 401 04- .

7.2 Side trims - replace

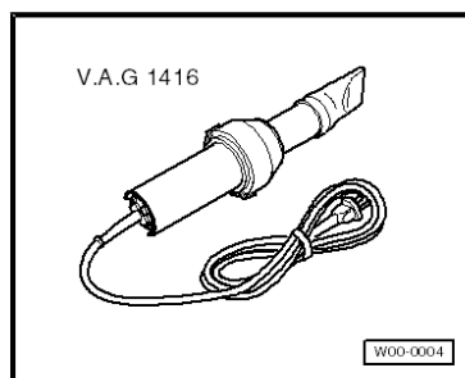


WARNING

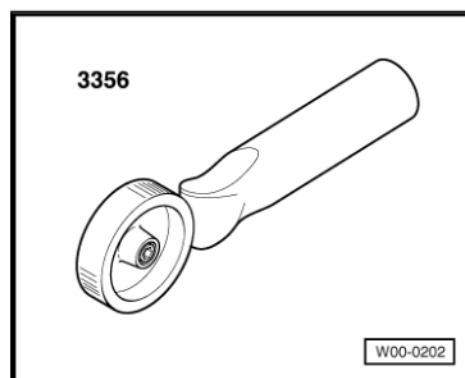
- ◆ *When handling chemicals follow the safety instructions ⇒ Chemical Products Manual; Rep. gr. 00*
- ◆ *Assignment of Chemical Materials ⇒ Electronic Parts Catalogue "ETKA"*

Special tools and workshop equipment required

- ◆ Hot air blower - VAG 1416-



- ◆ Pressure roll - 3356-



Side trims:



1 - Trim adhesion area

- ☐ Clean the area using adhesive remover - D 002 000 A2- , then apply the cleaning solution - D 009 401 04- .

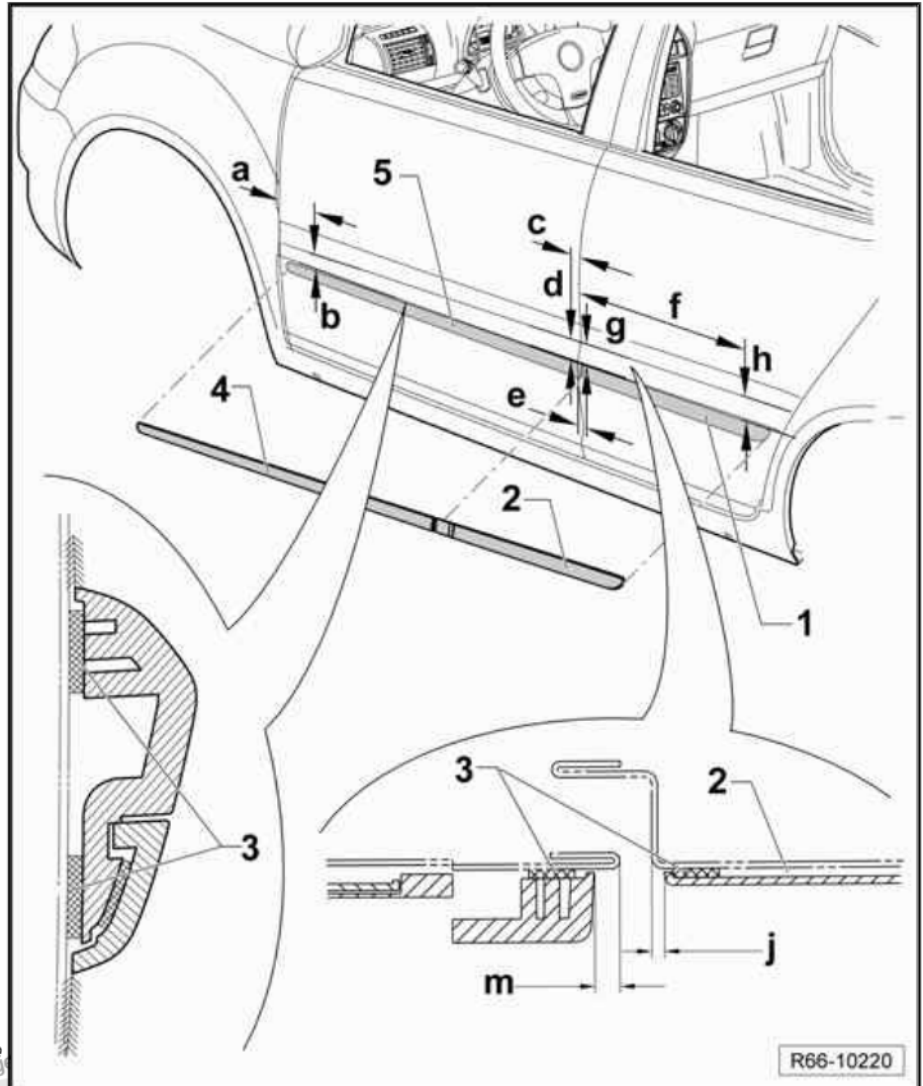
2 - Rear door trim

- ☐ Self-adherent
- ☐ Remove
 - Unglue the trim with the hot air blower - VAG 1416- , for easing the removal.
 - Remove all dirt and oiliness.
 - Remove adhesive residues with the adhesive remover - D 002 000 A2- and apply the cleaning solution - D 009 401 04- . Rub the surface with a cloth until it is completely dry.
- ☐ Install
 - Heat up trim and surface with hot air blower - VAG 1416- to make installation easier.
 - Remove the liner from the double-sided adhesive tape, position the trim and press with the pressure roll - 3356- .



Note

Operating temperature
C.



- ◆ e = 2.0 mm
- ◆ f = 594.5 mm
- ◆ g = 7.0 mm
- ◆ h = 8.2 mm
- ◆ j = 1.7 mm

3 - Double-sided adhesive tape

- ☐ The adhesive tape adhesion area must be completely free of dirt.
- ☐ Under no circumstances should the self-adhesive surface of the tape be touched.

4 - Front door trim

- ☐ Self-adherent
- ☐ Remove
 - Unglue the trim with the hot air blower - VAG 1416- , for easing the removal.
 - Remove all dirt and oiliness.
 - Remove adhesive residues with adhesive remover - D 002 000 A2- and apply cleaning solution - D 009 401 04- . Rub the surface with a cloth until it is completely dry.
- ☐ Install
 - Heat up trim and surface with hot air blower - VAG 1416- to make installation easier.
 - Remove the liner from the double-sided adhesive tape, position the trim and press with the pressure roll - 3356- .



Note

*Operating temperature approx. 20°
C.*

- ◆ a = 177 mm
- ◆ b = 5.4 mm
- ◆ c = 4.3 mm
- ◆ d = 6.9 mm
- ◆ m = 3.3 mm

5 - Trim adhesion area

- ❑ Clean the area using adhesive remover - D 002 000 A2- , then apply the cleaning solution - D 009 401 04- .

7.3 Side trims (Fox Prime) - replace

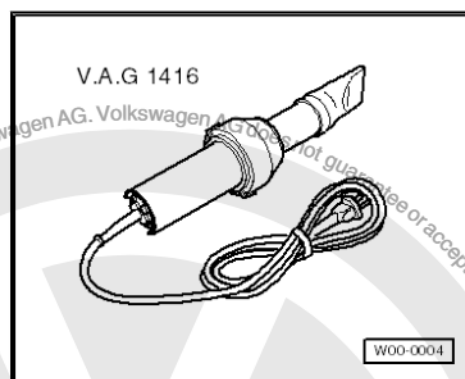


WARNING

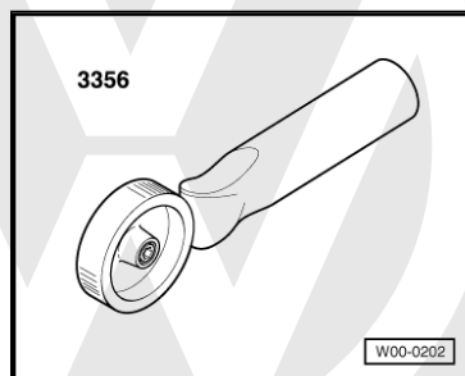
- ◆ *When handling chemicals follow the safety instructions ⇒ Chemical Products Manual; Rep. gr. 00*
- ◆ *Assignment of Chemical Materials ⇒ Electronic Parts Catalogue "ETKA"*

Special tools and workshop equipment required

- ◆ Hot air blower - VAG 1416-



- ◆ Pressure roll - 3356-



Side trims:



1 - Front door trim gluing area

- ☐ Clean the adhesion area with the cleaning solution - D 009 401 04- . Rub the surface with a cloth until it is completely dry.

2 - Front rear door / side panel trim gluing area

- ☐ Clean the adhesion area with the cleaning solution - D 009 401 04- . Rub the surface with a cloth until it is completely dry.

3 - Front door trim

- ☐ Self-adherent
- ☐ Dimension "a" = 100 mm
- ☐ Dimension "b" = 7.1 mm
- ☐ Dimension "c" = 8.15 mm
- ☐ Dimension "g" = 3.5 mm
- ☐ Remove

- Unglue the trim with the hot air blower - VAG 1416- , for easing the removal.

- Remove all dirt and oiliness.

- Remove adhesive residue with the cleaning solution - D 009 401 04- . Rub the surface with a cloth until it is completely dry.

- ☐ Install

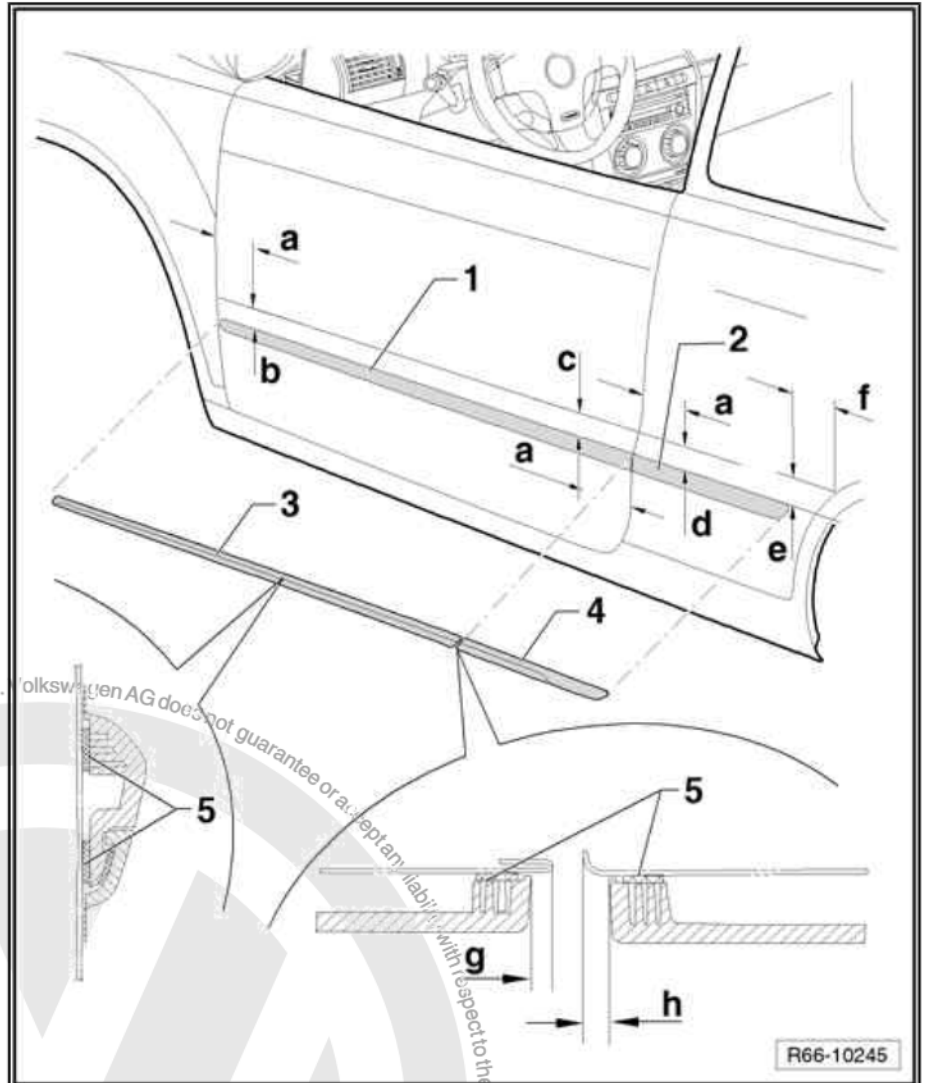
- Heat up previously the trim and the adhesion area with the hot air blower - VAG 1416- , to facilitate the installation.

- Remove the liner from the double-sided adhesive tape, position the trim and press with the pressure roll - 3356- .



Note

Operating temperature approx. 20°



4 - Rear door / side panel trim

- ☐ Self-adherent
- ☐ Dimension "a" = 100 mm
- ☐ Dimension "d" = 8.5 mm
- ☐ Dimension "e" = 9.11 mm
- ☐ Dimension "f" = 200 mm
- ☐ Dimension "h" = 4.3 mm
- ☐ Remove

- Unglue the trim with the hot air blower - VAG 1416- , for easing the removal.



- Remove adhesive residue with the cleaning solution - D 009 401 04- . Rub the surface with a cloth until it is completely dry.
- ☐ Install
- Heat up previously the trim and the adhesion area with the hot air blower - VAG 1416- , to facilitate the installation.
- Remove the liner from the double-sided adhesive tape, position the trim and press with the pressure roll - 3356- .



Note

*Operating temperature approx. 20°
C.*

5 - Double-sided adhesive tape

- ☐ The adhesive tape adhesion area must be completely free of dirt.
- ☐ Under no circumstances should the self-adhesive surface of the tape be touched.

7.4 Side trims - replace

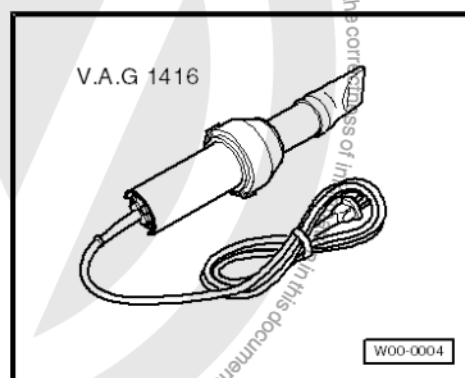


WARNING

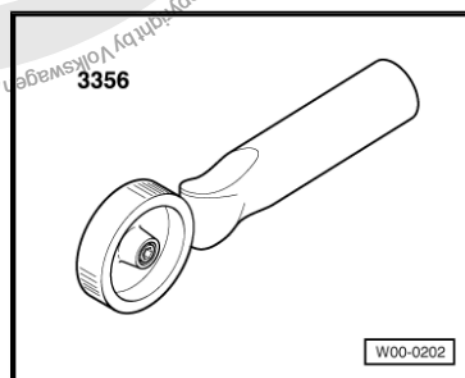
- ◆ *When handling chemicals follow the safety instructions ⇒ Chemical Products Manual; Rep. gr. 00*
- ◆ *Assignment of Chemical Materials ⇒ Electronic Parts Catalogue "ETKA"*

Special tools and workshop equipment required

- ◆ Hot air blower - VAG 1416-



- ◆ Pressure roll - 3356-



Side trims:



1 - Front door trim gluing area

- ☐ Clean the adhesion area with the cleaning solution - D 009 401 04- . Rub the surface with a cloth until it is completely dry.

2 - Front rear door / side panel trim gluing area

- ☐ Clean the adhesion area with the cleaning solution - D 009 401 04- . Rub the surface with a cloth until it is completely dry.

3 - Front door trim

- ☐ Self-adherent
- ☐ Dimension "a" = 100 mm
- ☐ Dimension "b" = 7.1 mm
- ☐ Dimension "c" = 7.1 mm
- ☐ Dimension "f" = 2.0 mm
- ☐ Remove
- Unglue the trim with the hot air blower - VAG 1416- , for easing the removal.
- Remove all dirt and oiliness.
- Remove adhesive residue with the cleaning solution - D 009 401 04- . Rub the surface with a cloth until it is completely dry.

- ☐ Install

- Heat up previously the trim and the adhesion area with the hot air blower - VAG 1416- , to facilitate the installation.
- Remove the liner from the double-sided adhesive tape, position the trim and press with the pressure roll - 3356- .

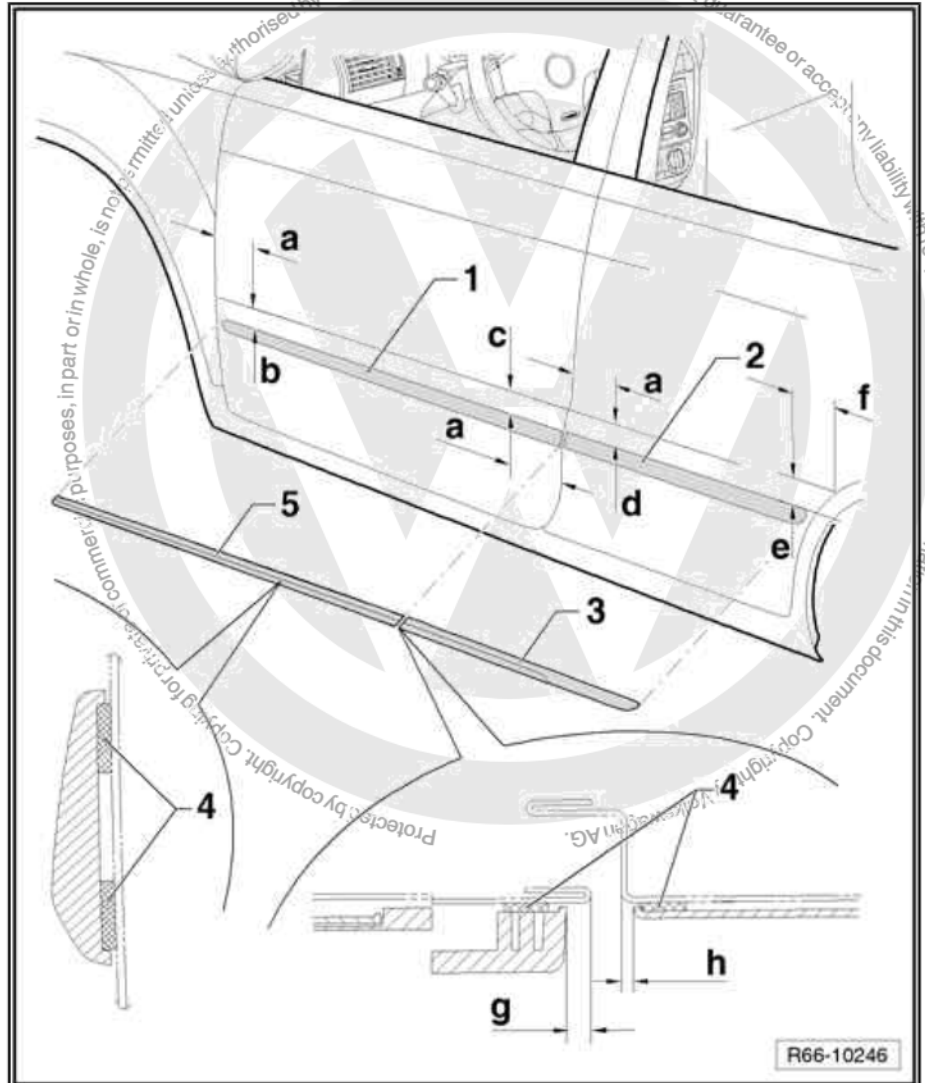


Note

Operating temperature approx. 20° C.

4 - Rear door / side panel trim

- ☐ Self-adherent
- ☐ Dimension "a" = 100 mm
- ☐ Dimension "d" = 8.2 mm
- ☐ Dimension "e" = 9.2 mm
- ☐ Dimension "g" = 2.5 mm
- ☐ Remove
- Unglue the trim with the hot air blower - VAG 1416- , for easing the removal.





- Remove adhesive residue with the cleaning solution - D 009 401 04- . Rub the surface with a cloth until it is completely dry.
- ☐ Install
- Heat up previously the trim and the adhesion area with the hot air blower - VAG 1416- , to facilitate the installation.
- Remove the liner from the double-sided adhesive tape, position the trim and press with the pressure roll - 3356- .



Note

*Operating temperature approx. 20°
C.*

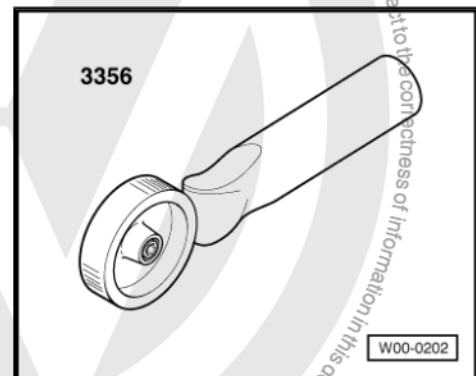
5 - Double-sided adhesive tape

- ☐ The adhesive tape adhesion area must be completely free of dirt.
- ☐ Under no circumstances should the self-adhesive surface of the tape be touched.

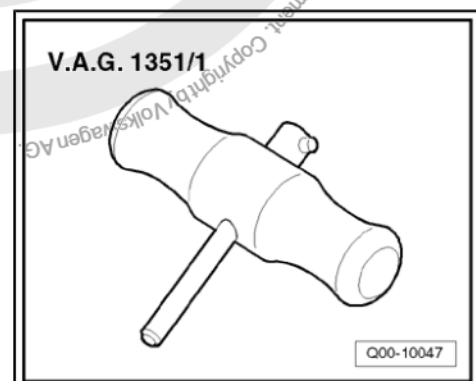
7.5 Door trims (Space Cross / Suran Cross) - Assembly overview

Special tools and workshop equipment required

◆ Pressure roll - 3356-

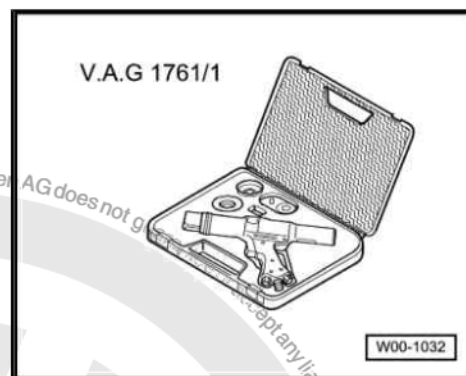


◆ Traction cable - VAG 1351/1-





- ◆ Pneumatic Adhesive Applicator - VAG 1761/1- or Adhesive applicator for glued glass - VAG 1628-



1 - Rear door trim

- ☐ Self-adherent
- ☐ Replace ⇒ [page 251](#)
- ☐ Dimension "a" = 100 mm
- ☐ Dimension "d" = 29.3 mm
- ☐ Dimension "e" = 30.5 mm
- ☐ Dimension "f" = 2.5 mm
- ☐ Dimension "g" = 8,9 ± 0,7 mm
- ☐ Dimension "h" = 2.2 mm

2 - Front door trim

- ☐ Self-adherent
- ☐ Replace ⇒ [page 246](#)
- ☐ Dimension "a" = 100 mm
- ☐ Dimension "b" = 22.1 mm
- ☐ Dimension "c" = 28.1 mm

3 - Double-sided adhesive tape

- ☐ The adhesive tape adhesion area must be completely free of dirt.
- ☐ Under no circumstances should the self-adhesive surface of the tape be touched.

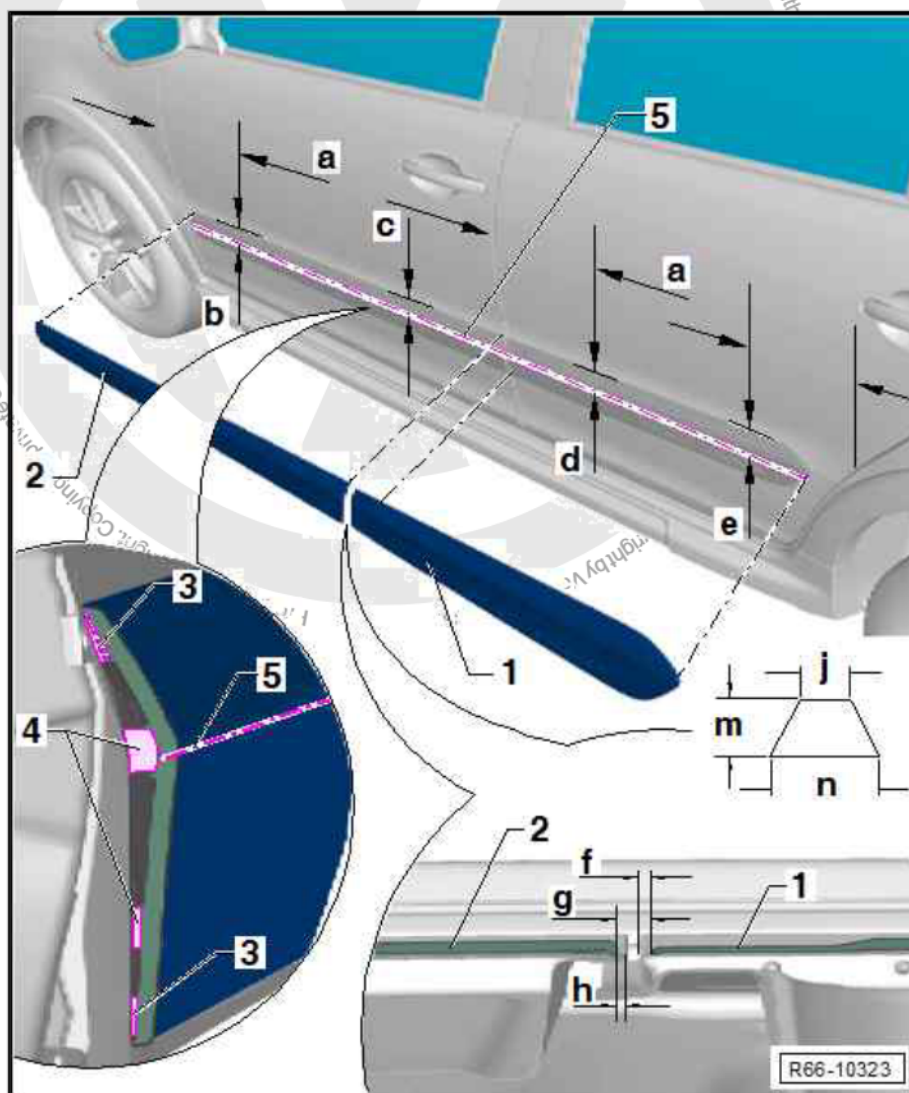


Note

Operating temperature approx. 20° C.

4 - PU adhesive bead

- ☐ "j" = 7 mm
- ☐ "m" = 8 mm
- ☐ "n" = 9 mm
- ☐ Respect the minimum drying time. ⇒ [page 162](#)



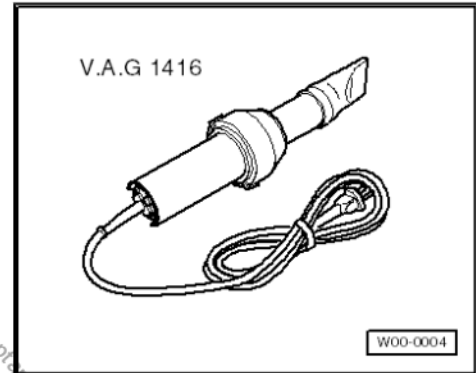


❑ Matching table ➔ [page 161](#)

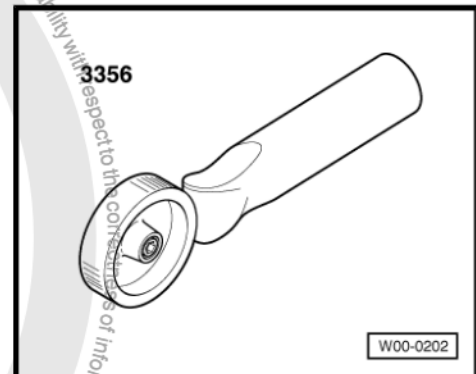
7.6 Front door trim (Space Cross / Suran Cross) - replace

Special tools and workshop equipment required

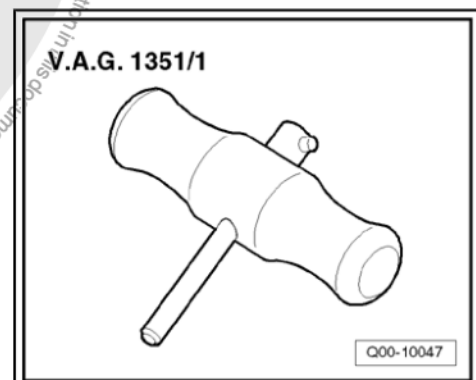
◆ Hot air blower - VAG 1416-



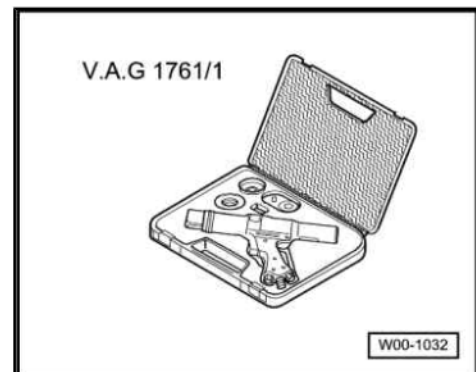
◆ Pressure roll - 3356-



◆ Traction cable - VAG 1351/1-



◆ Pneumatic Adhesive Applicator - VAG 1761/1- or Adhesive applicator for glued glass - VAG 1628-





7.6.1 Observations for operational execution

Auxiliary materials Brazilian market ⇒ [page 160](#)

Auxiliary materials for the export market ⇒ [page 160](#)

Matching table ⇒ [page 161](#)

Minimum adhesive curing time ⇒ [page 162](#)

Cleaning in case of dirt residues resulting from handling of polyurethane adhesive (PU) ⇒ [page 162](#)

Paintwork damage - repair ⇒ [page 161](#)

7.6.2 Removal

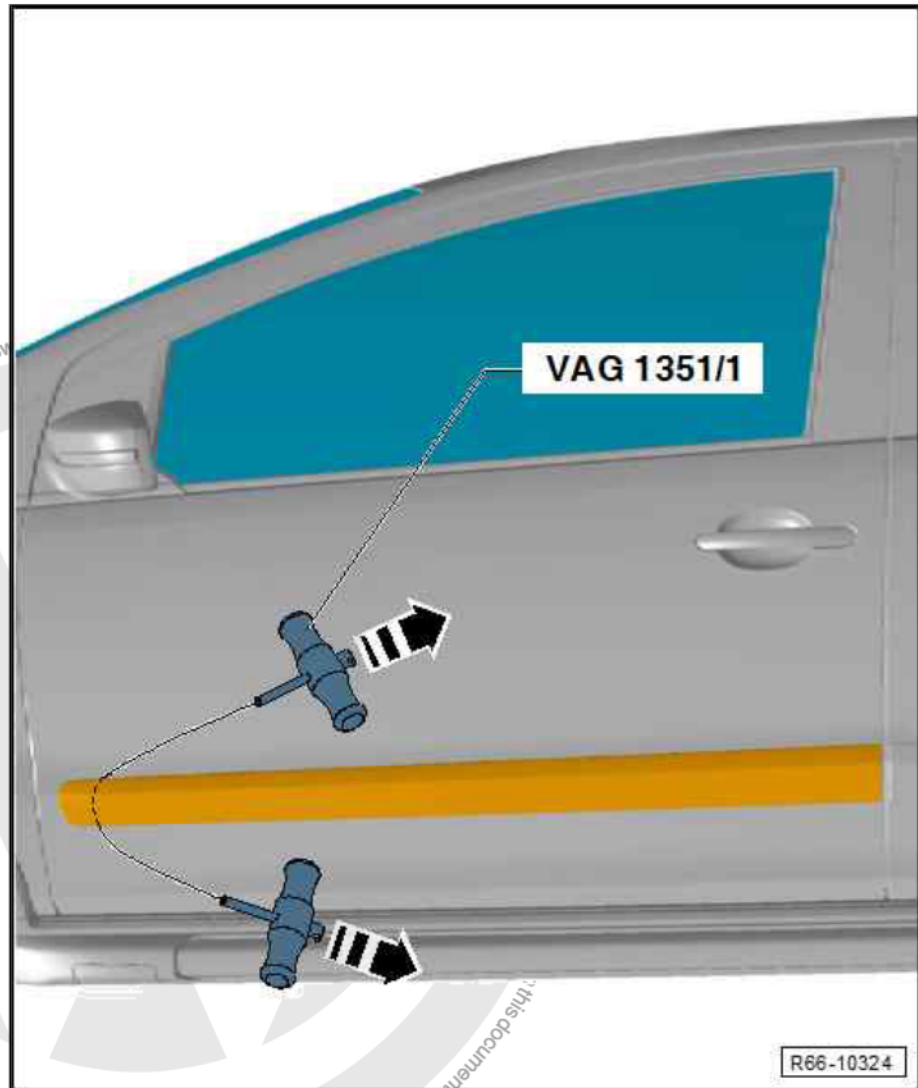


WARNING

- ◆ *When handling chemicals follow the safety instructions ⇒ Chemical Products Manual; Rep. gr. 00*
- ◆ *Assignment of Chemical Materials ⇒ Electronic Parts Catalogue "ETKA"*

- Protect the paint with adhesive tape.
- Before removing, you must heat up the trim with the hot air blower - VAG 1416- .





- Place the cutting wire - 357 853 999.A- between the door and trim.
- Use two traction cables - VAG 1351/1- to pull the cutting wire to section the adhesive bead.
- Cut the residual adhesive on the vehicle, reducing it to its minimum thickness.
- Remove all dirt and oiliness.
- Remove adhesive residue with the cleaning solution - D 009 401 04- . Rub the surface with a cloth until it is completely dry.

7.6.3 Installation

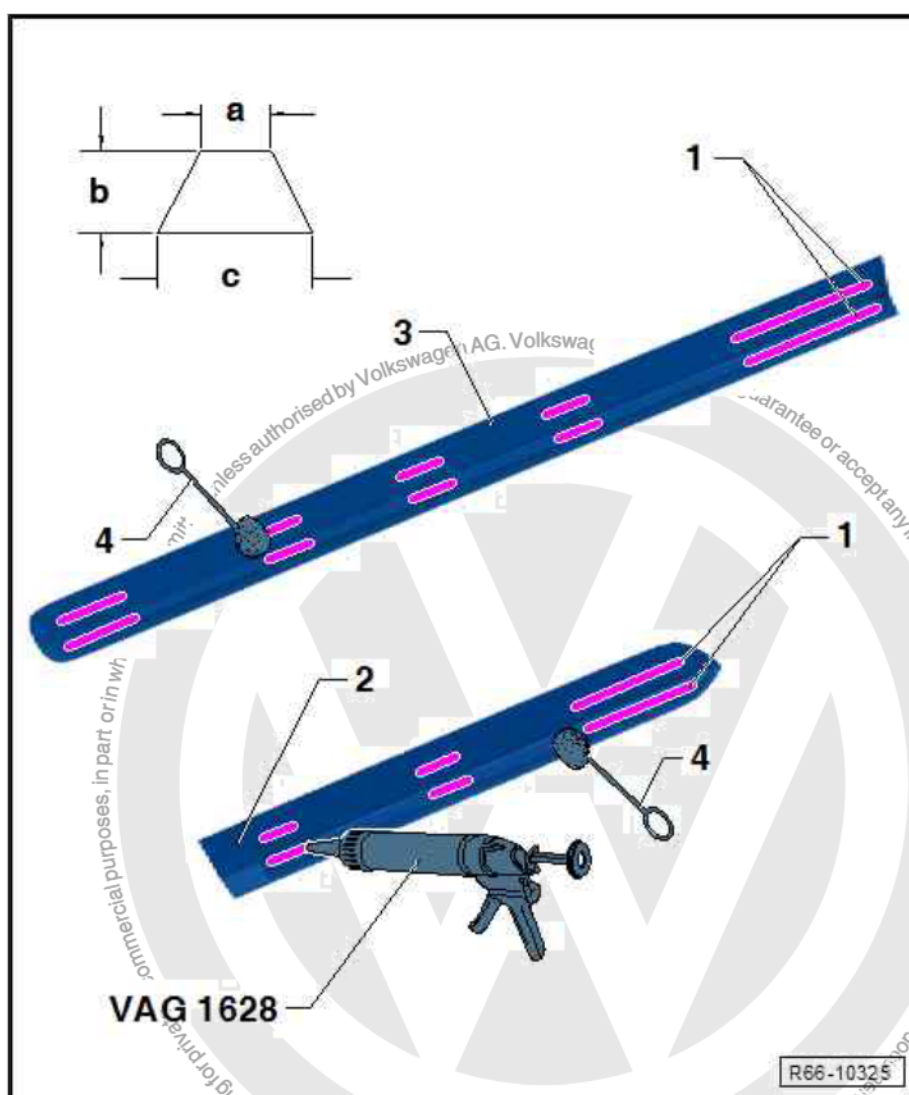
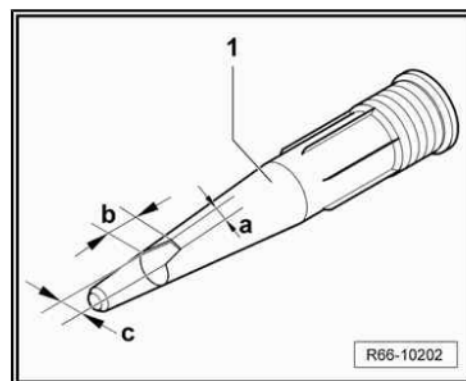


WARNING

- ◆ When handling chemicals follow the safety instructions ⇒ Chemical Products Manual; Rep. gr. 00
- ◆ Assignment of Chemical Materials ⇒ Electronic Parts Catalogue "ETKA"



- Cut adhesive dispenser -1- nozzle.
- 1 - Cut the nozzle to a 7-mm profile "a"
- 2 - Cut the nozzle to a 8-mm profile "b"
- 3 - Cut the nozzle to a 9-mm profile "c"
- Apply silicone remover - LSE 020 100 A3- onto the trim PU-adhesive application areas, and then apply cleaning solution - D 009 401 04- .



a = 7 mm

b = 8 mm

c = 9 mm

- Apply on areas that will be applied with PU adhesive, polypropylene surface activator - D 181 655 R1- with the applicator - D 009 500 25- -4-.



Note

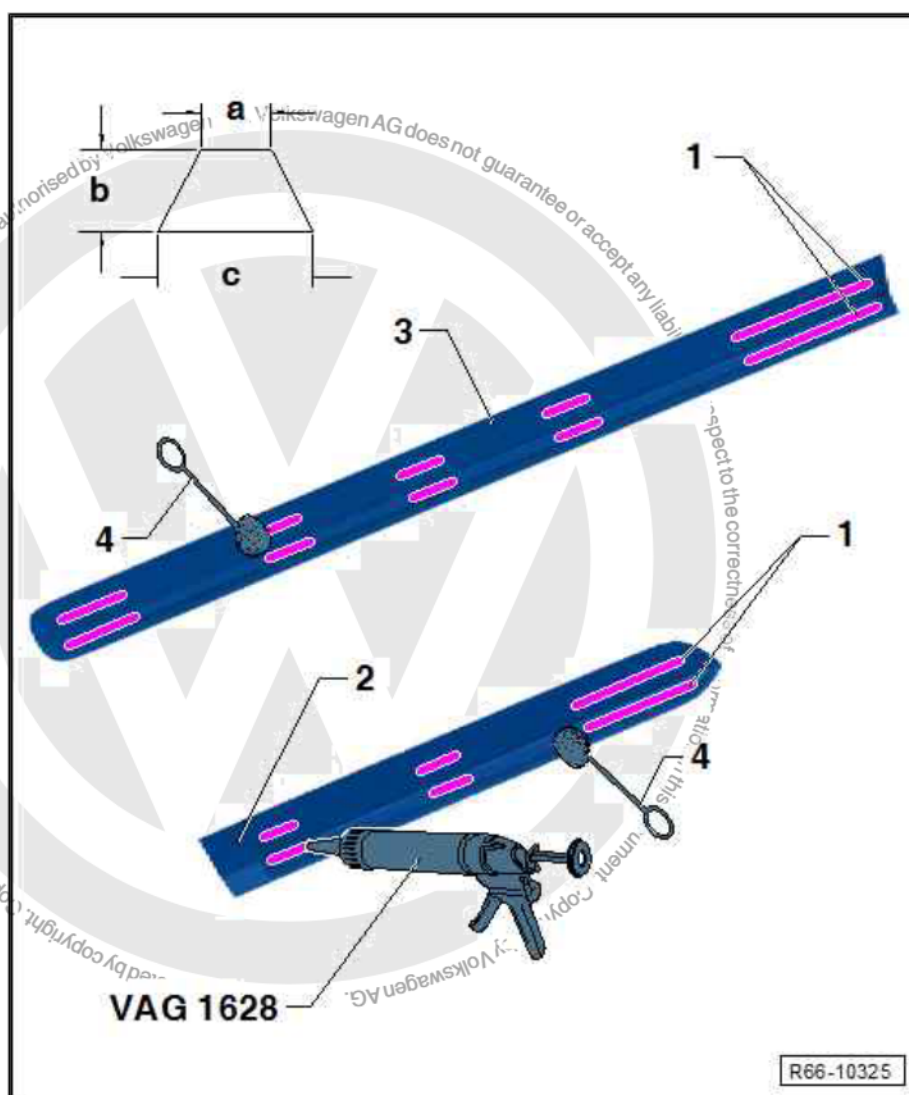
The activator performs the adhesion of PU adhesive. Wait 15 minutes until curing.

- Heat the DH 009 100 - 300 ml or DH 009 100 03 - 110 ml adhesive cartridge, according to the instructions of the cartridge heater - VAG 1939- before placing it in the applicator.



Note

See "Observations for operational execution" ⇒ [page 247](#)



a = 7 mm

b = 8 mm

c = 9 mm

- Apply 5 cords onto the upper section and 5 cords onto the lower section with 25 mm length and indicated -1-, near the rear door, 50 mm, using the Pneumatic adhesive applicator -



VAG 1761/1- or adhesive applicator for glued windows - VAG 1628- .



Note

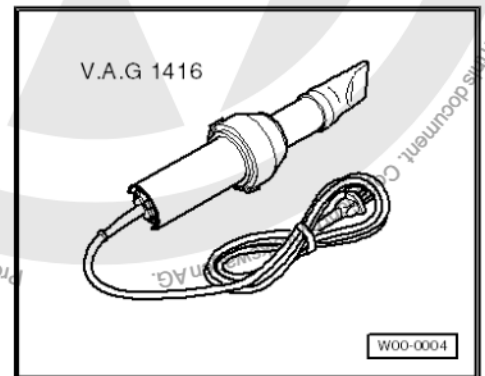
The time between the beginning of the application of the adhesive and the placement of the trim should not exceed 15 minutes.

- Heat up the adhesion area with the hot air blower - VAG 1416- to facilitate the installation.
- Remove adhesive tape liner, place lining and firmly press it with a pressure roll - 3356- . Wait for a minimum drying time ⇒ [page 162](#) .

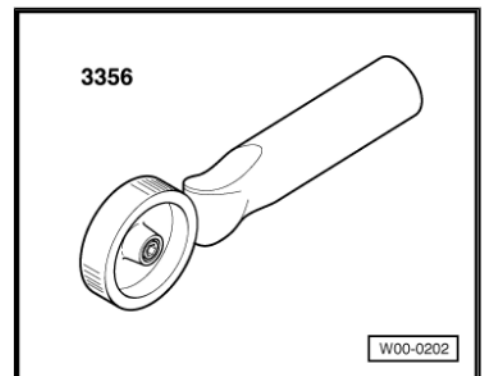
7.7 Rear door trim (Space Cross / Suran Cross and Crossfox 2013 ➤) - replace

Special tools and workshop equipment required

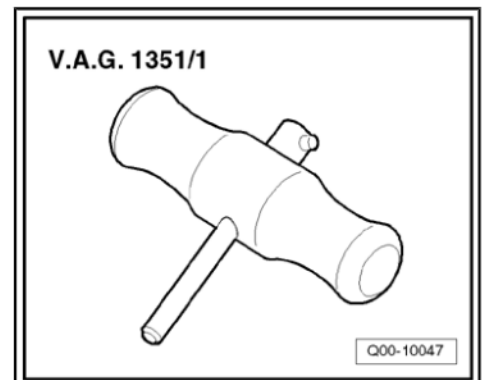
- ◆ Hot air blower - VAG 1416-



- ◆ Pressure roll - 3356-

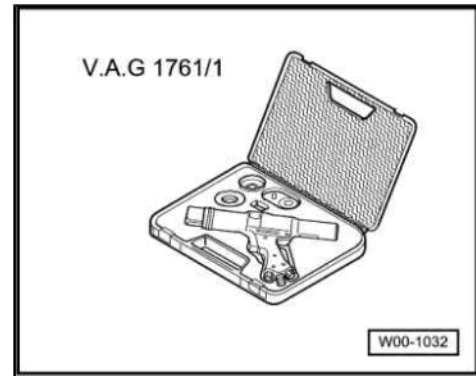


- ◆ Traction cable - VAG 1351/1-





- ◆ Pneumatic Adhesive Applicator - VAG 1761/1- or Adhesive applicator for glued glass - VAG 1628-



7.7.1 Observations for operational execution

Auxiliary materials Brazilian market ⇒ [page 160](#)

Auxiliary materials for the export market ⇒ [page 160](#)

Matching table ⇒ [page 161](#)

Minimum adhesive curing time ⇒ [page 162](#)

Cleaning in case of dirt residues resulting from handling of polyurethane adhesive (PU) ⇒ [page 162](#)

Paintwork damage - repair ⇒ [page 161](#)

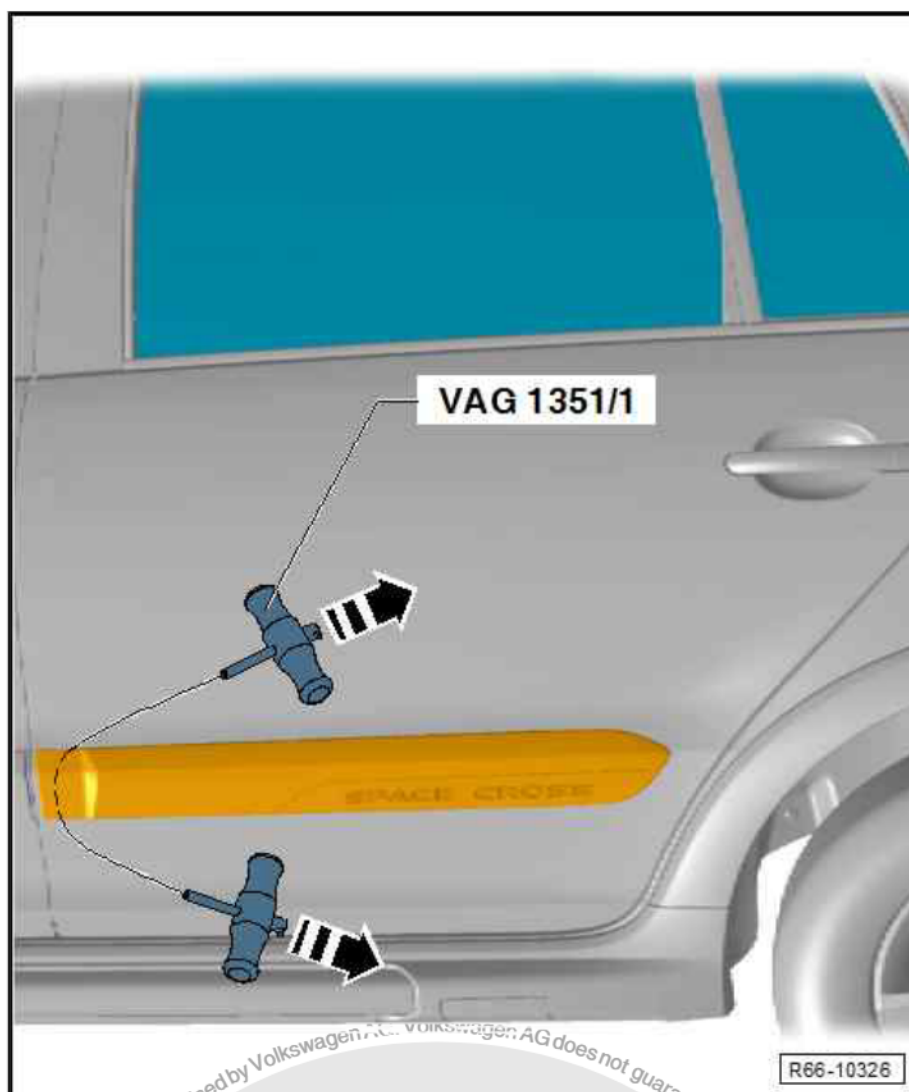
7.7.2 Removal



WARNING

- ◆ When handling chemicals follow the safety instructions ⇒ *Chemical Products Manual; Rep. gr. 00*
- ◆ Assignment of Chemical Materials ⇒ *Electronic Parts Catalogue "ETKA"*

- Protect the paint with adhesive tape.
- Before removing, you must heat up the trim with the hot air blower - VAG 1416- .

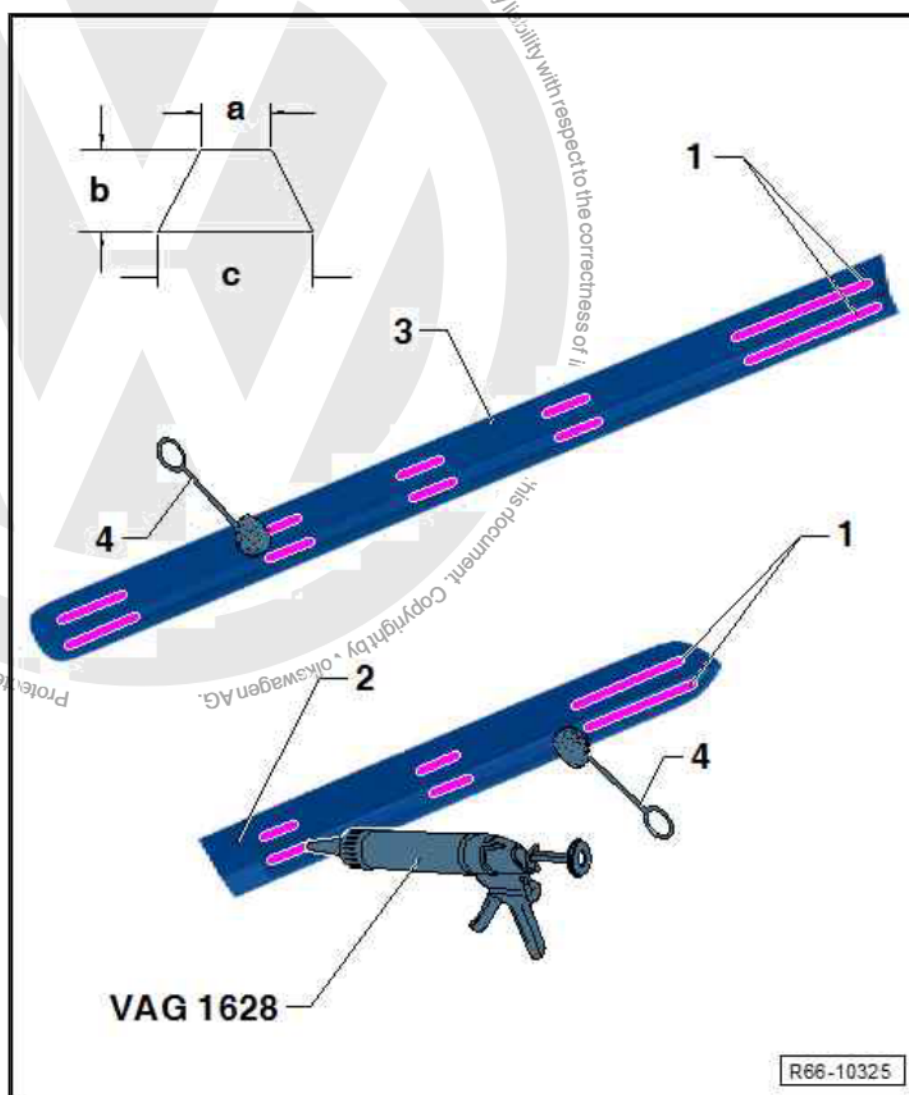
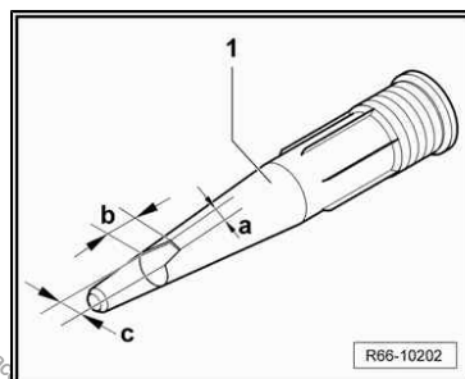


- Place the cutting wire - 357 853 999 A- between the door and trim.
- Use two traction cables - VAG 1351/1- to pull the cutting wire to section the adhesive bead.
- Cut the residual adhesive on the vehicle, reducing it to its minimum thickness.
- Remove all dirt and oiliness.
- Remove adhesive residue with the cleaning solution - D 009 401 04- . Rub the surface with a cloth until it is completely dry.



7.7.3 Installation

- Cut adhesive dispenser -1- nozzle.
- 1 - Cut the nozzle to a 7-mm profile "a"
- 2 - Cut the nozzle to a 8-mm profile "b"
- 3 - Cut the nozzle to a 9-mm profile "c"
- Apply silicone remover - LSE 020 100 A3- onto the trim PU-adhesive application areas, and then apply cleaning solution - D 009 401 04- .



a = 7 mm

b = 8 mm

c = 9 mm

- Apply on areas that will be applied with PU adhesive, polypropylene surface activator - D 181 655 R1- with the applicator - D 009 500 25- -4-.



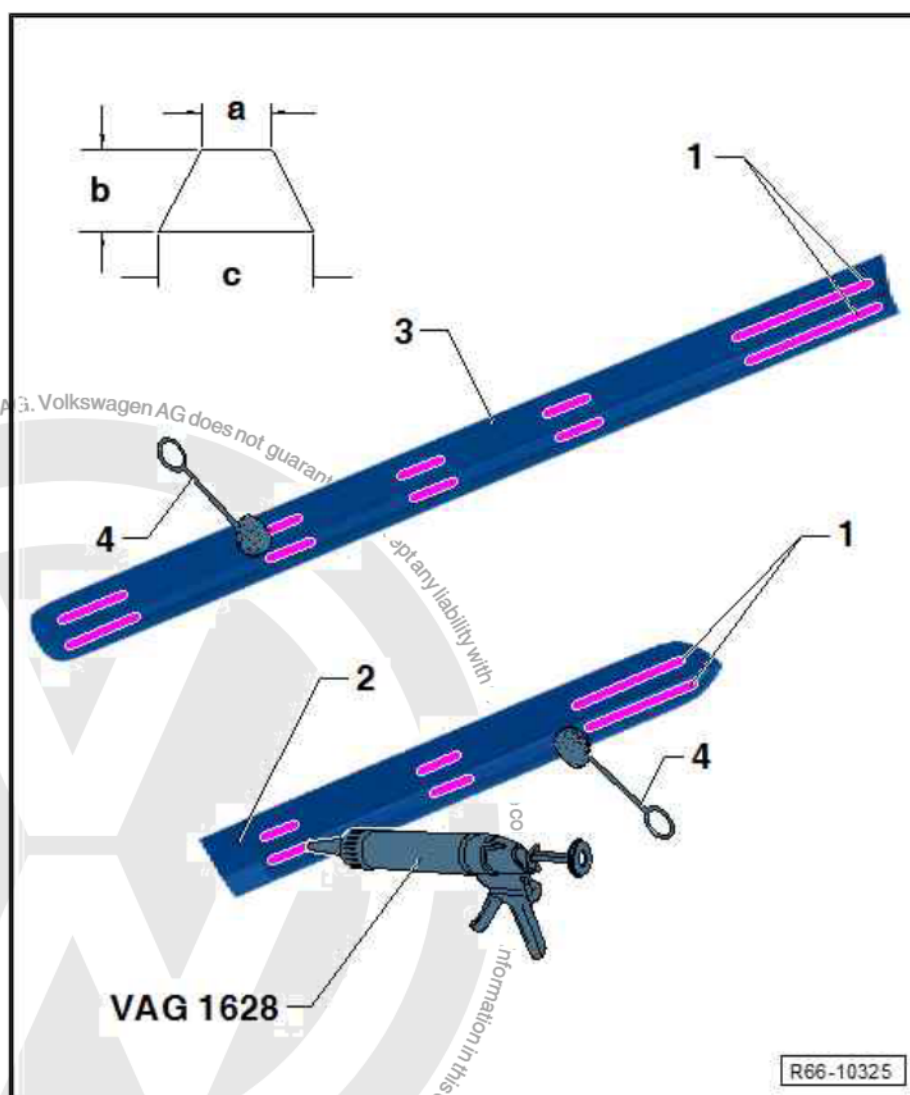
i Note

The activator performs the adhesion of PU adhesive. Wait 15 minutes until curing.

- Heat the DH 009 100 - 300 ml or DH 009 100 03 - 110 ml adhesive cartridge, according to the instructions of the cartridge heater - VAG 1939- before placing it in the applicator.

i Note

See "Observations for operational execution" ⇒ [page 252](#)



a = 7 mm

b = 8 mm

c = 9 mm

- Apply 3 cords onto the upper section and 3 cords onto the lower section with 25 mm length and indicated -1-, near the rear side panel, 50 mm, using the Pneumatic adhesive appli-



cator - VAG 1761/1- or adhesive applicator for glued windows
- VAG 1628- .



Note

The time between the beginning of the application of the adhesive and the placement of the trim should not exceed 15 minutes.

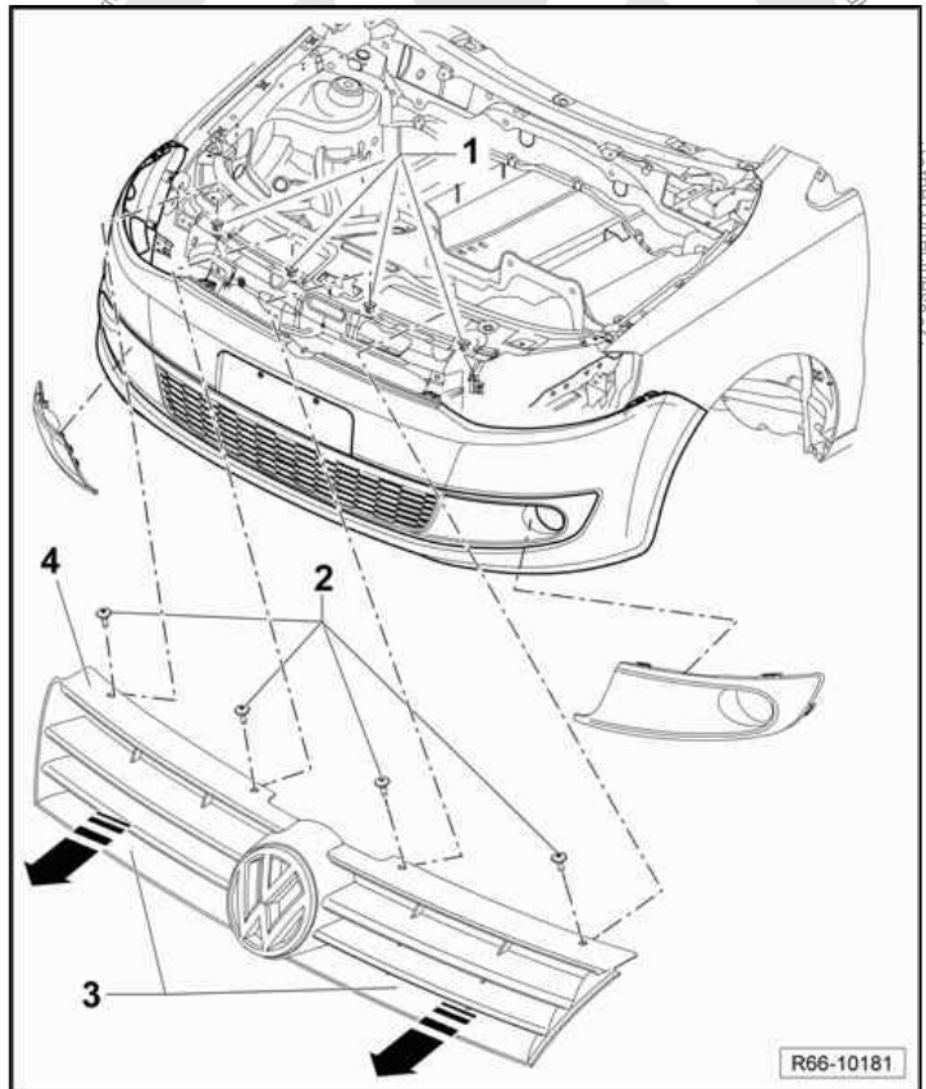
- Heat up the adhesion area with the hot air blower - VAG 1416- to facilitate the installation.
- Remove adhesive tape liner, place lining and firmly press it with a pressure roll - 3356- . Wait for a minimum drying time
[⇒ page 162](#) .



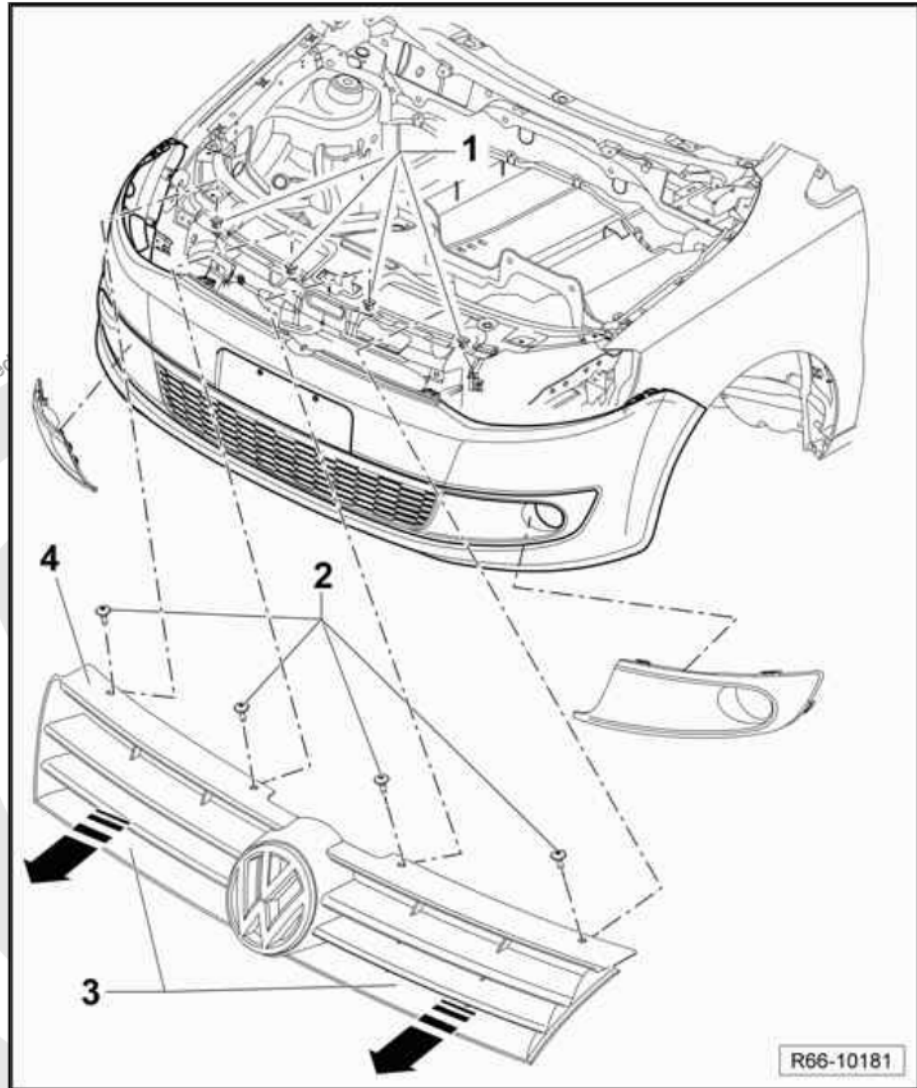
8 Front grid

8.1 Front bonnet - remove and install

- 1 - Bushing
 - ☐ 4 units
 - ☐ Replace, as required
- 2 - Bolt
 - ☐ 4 units
 - ☐ Torque: 1.5 Nm
- 3 - Hand support area for grid removal
- 4 - Front grid with badge



Removal:



- Remove the bolts -4-.
- With hands placed in area -3-, disengage bumper front protector grid.



Caution

Use of safety gloves is recommended because of the front grid's pointed edges.

Installation:

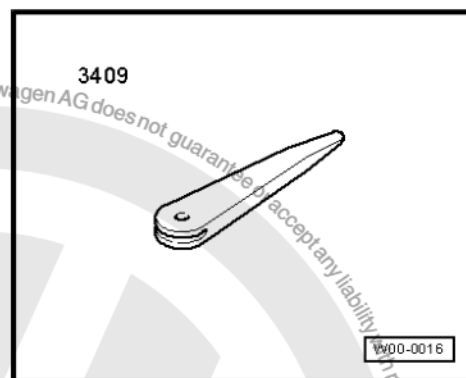
- Installation is performed in the reverse sequence to the removal.

8.2 Front grid (Bluemotion) - remove and install

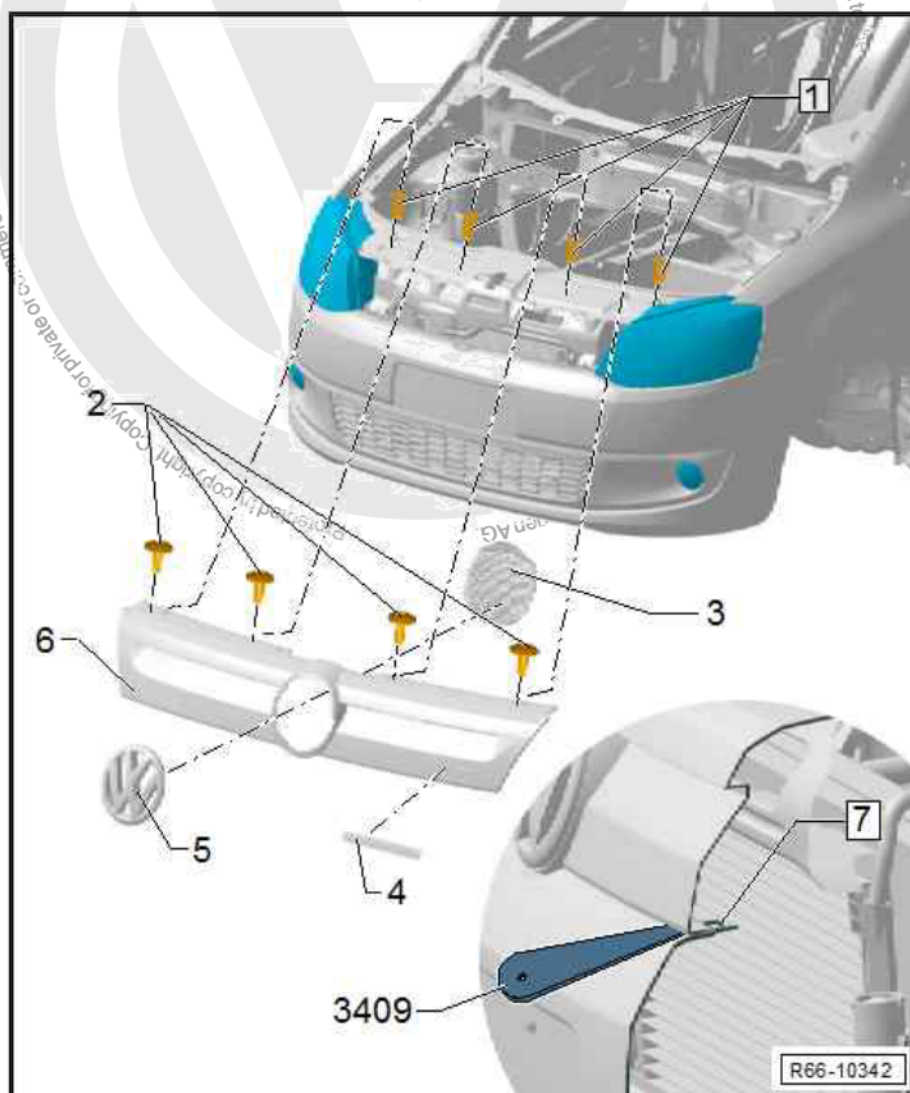
Special tools and workshop equipment required



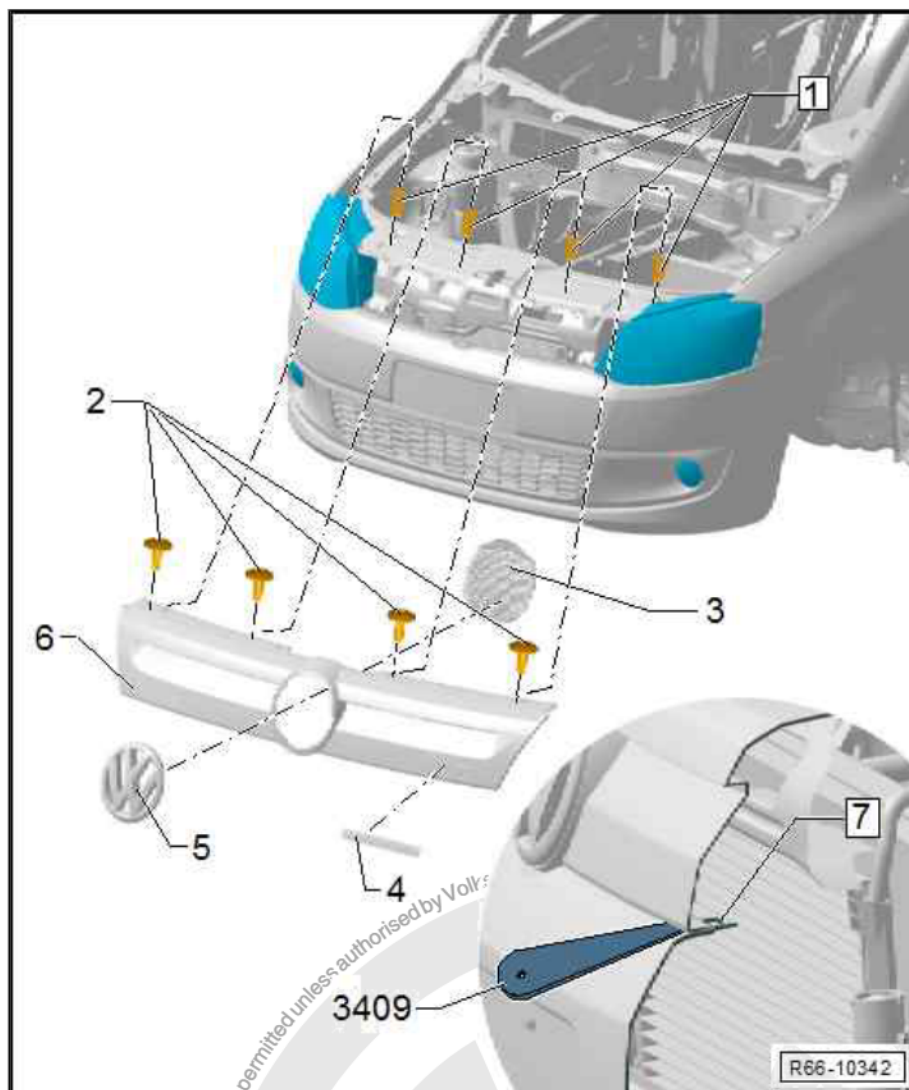
◆ Wedge - 3409-



- 1 - Bushing
 - ☐ 4 units
 - ☐ Replace it if necessary.
- 2 - Bolt
 - ☐ 4 units
 - ☐ Torque: 1.5 Nm
- 3 - Hand support area for grid removal
- 4 - Front grid
- 5 - Front badge
 - ☐ Inserted into the grill
- 6 - "Bluemotion" Badge
 - ☐ The lettering adhesion area must be completely free of dirt
 - ☐ Under no circumstances should the self-adhesive surface be touched.
- 7 - Locking tab



Removal:



- Remove the bolts -2-.
- With the nylon wedge, - 3409- unlock the tab -7- and disconnect the front bumper protector grid.



Caution

Use of safety gloves is recommended because of the front grid's pointed edges.

Installation:

- Installation is performed in the reverse sequence to the removal.



8.3 Radiator grille (Crossfox and Space Cross / Suran Cross) - remove and install

1 - Bushing

☐ 4 units

☐ Replace, as required

2 - Front protector

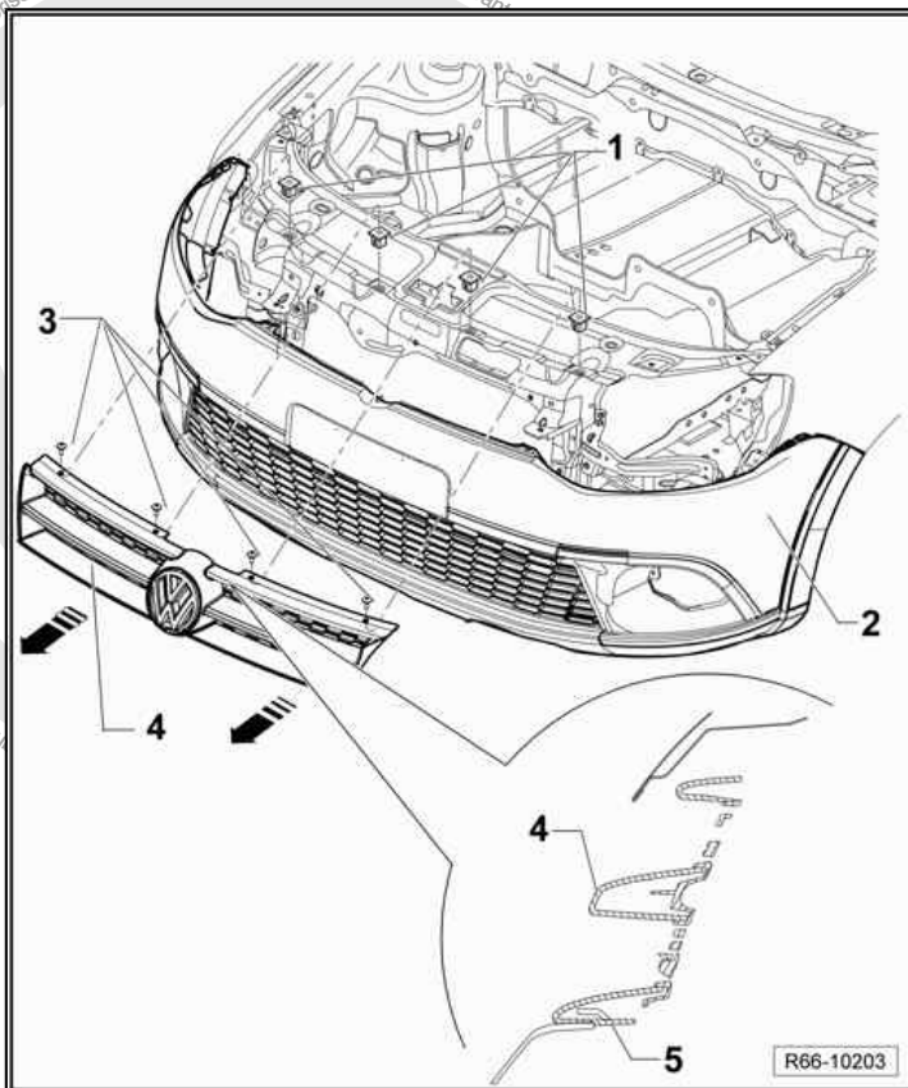
3 - Bolt

☐ 4 units

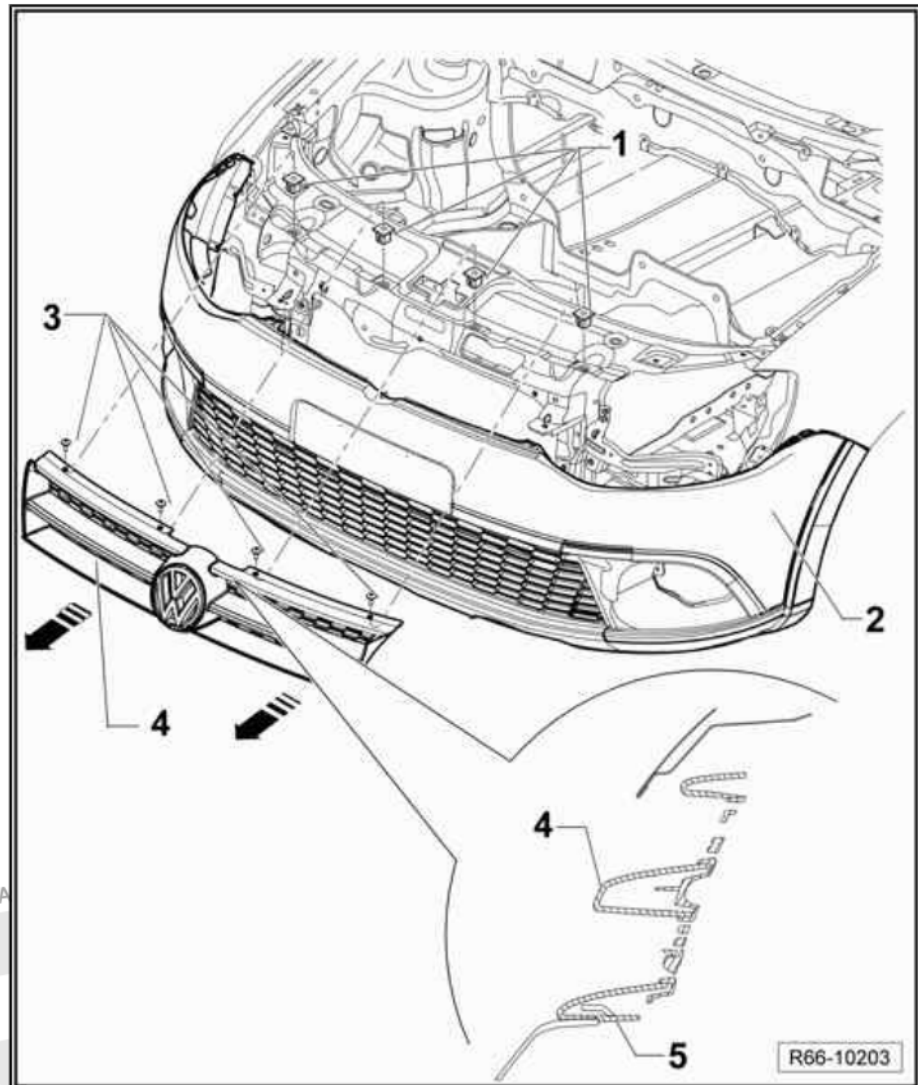
☐ Torque: 15 Nm

4 - Front grid with badge

5 - Lower fastening tab



Removal:



- Remove the bolts -3-.
- Press the front grid with your hands to disengage tab -5- from bumper front protector.



Caution

Use of safety gloves is recommended because of the front grid's pointed edges.

Installation:

- Installation is performed in the reverse sequence to the removal.



9 Wheel arch protector

9.1 Front wheel arch protector - remove and install

1 - Wheel arch protector

☐ Remove:

- Remove the wheel arch protector.
Tightening torque for the wheel screws ➤ Chassis; Rep. gr. 44 ; Wheels, tires, vehicle dimensions
- Remove screws -2- and wheel arch protector.

2 - Bolt

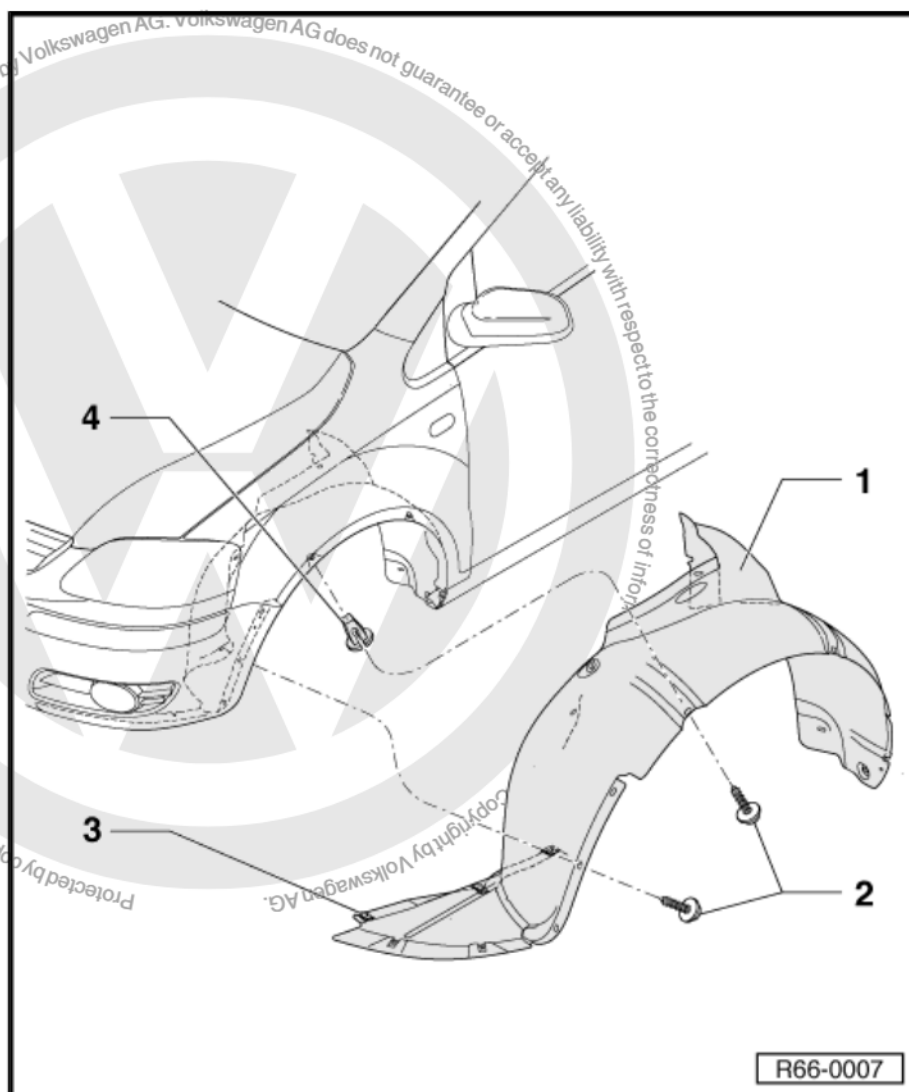
- ☐ 13 units
- ☐ Torque: 1.5 Nm

3 - Speed nut

- ☐ 3 units

4 - Bushing

- ☐ 8 units
- ☐ Replace as required





9.2 Rear wheel arch protector (Fox) - remove and install

1 - Wheel arch protector

☐ Remove:

- Remove the wheel.
Tightening torque for
the wheel screws is
Chassis; Rep. gr. 44 ;
Wheels, tires, vehicle di-
mensions
- Remove screws -3- and
wheel arch protector.

2 - Speed nut

☐ 3 units

3 - Bolt

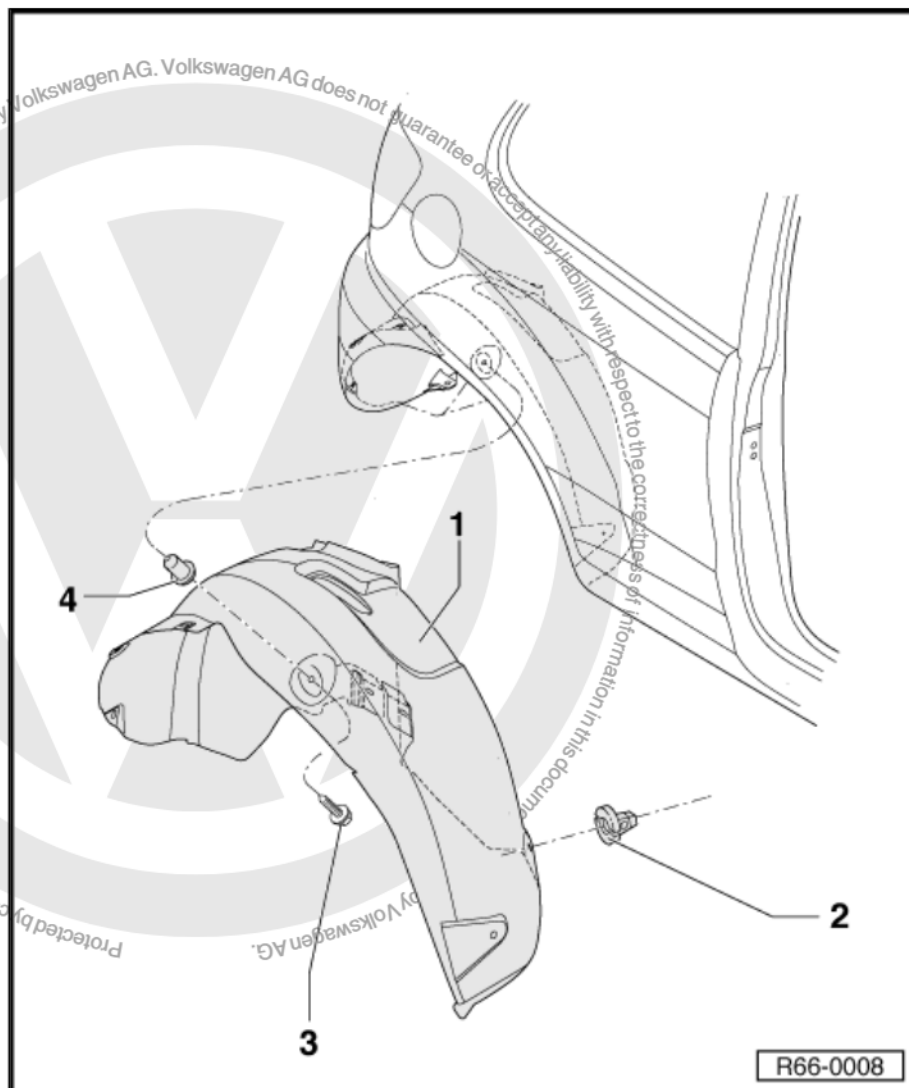
☐ 8 units

☐ Torque: 1.5 Nm

4 - Bushing

☐ 2 units

☐ Replace, as required





9.3 Rear wheel arch protector (Spacefox / Suran) - remove and install

1 - Rear wheel case protector

☐ Remove:

- Remove the wheel.
Tightening torque for
the wheel screws \Rightarrow
Chassis; Rep. gr. 44 ;
Wheels, tires, vehicle di-
mensions
- Remove screws -3- and
wheel arch protector.

2 - Bushing

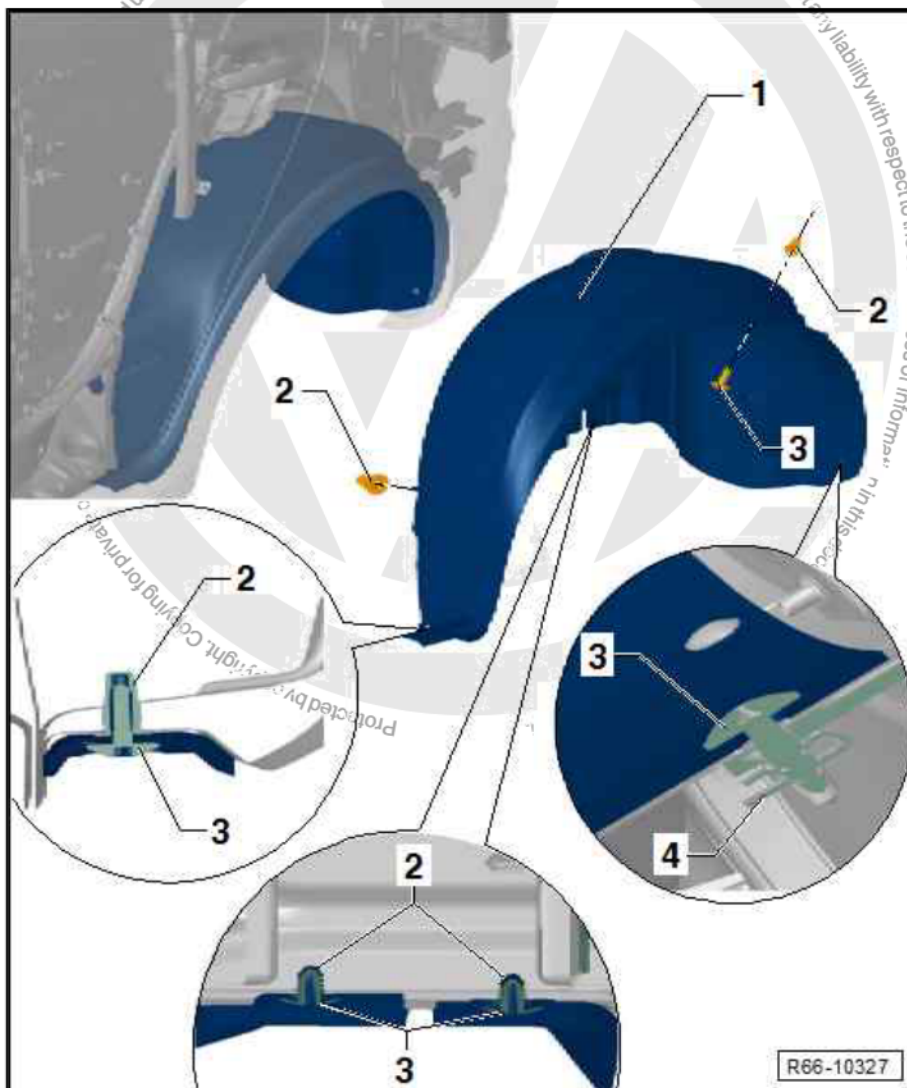
- ☐ 7 units
- ☐ Replace, as required

3 - Bolt

- ☐ 11 units
- ☐ Torque: 1.5 Nm

4 - Speed nut

- ☐ 4 units



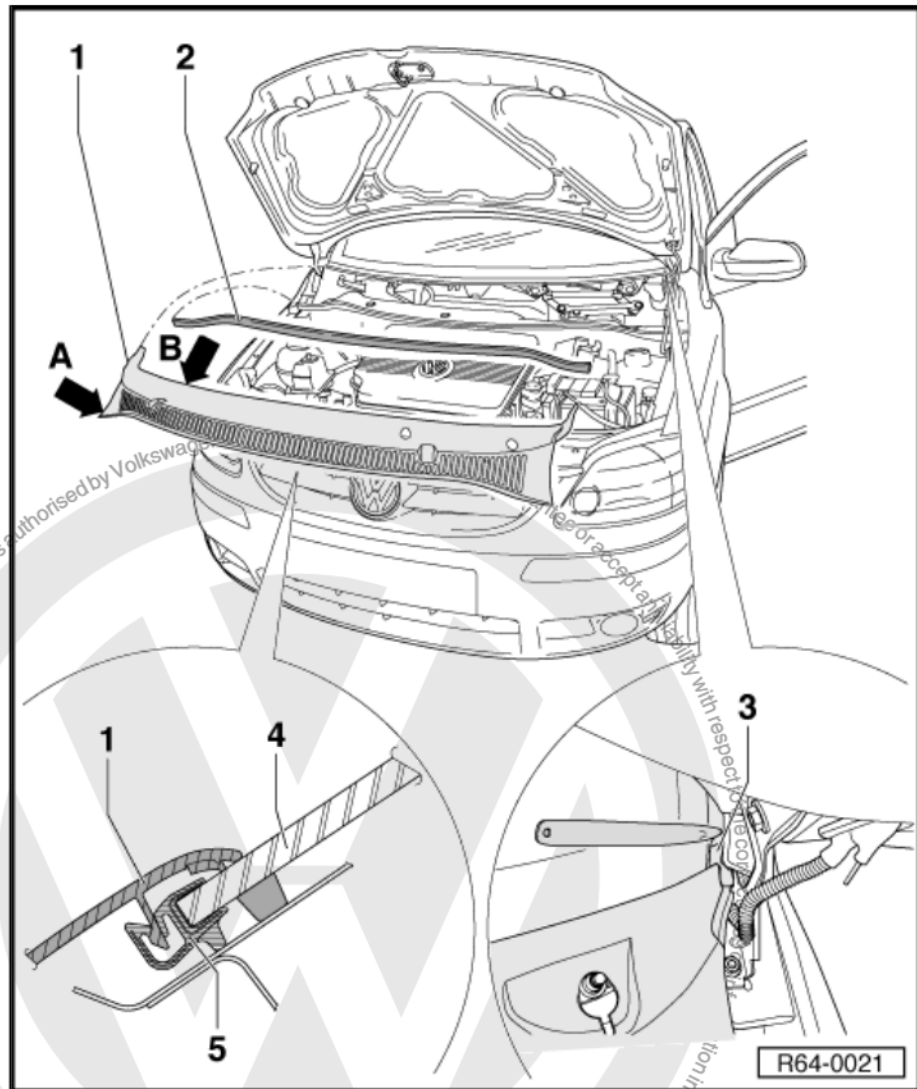
R66-10327



10 External linings

10.1 Lower windscreen covering - Assembly overview

- 1 - Windscreen lower trim
 - ❑ Remove and install
⇒ [page 266](#)
- 2 - Sealing trim
 - ❑ fitted to water reservoir
flange
- 3 - Cap
 - ❑ on water case cover.
- 4 - Windscreen
- 5 - Fitting trim



10.2 Windscreen lower trim - remove and install

Removal:

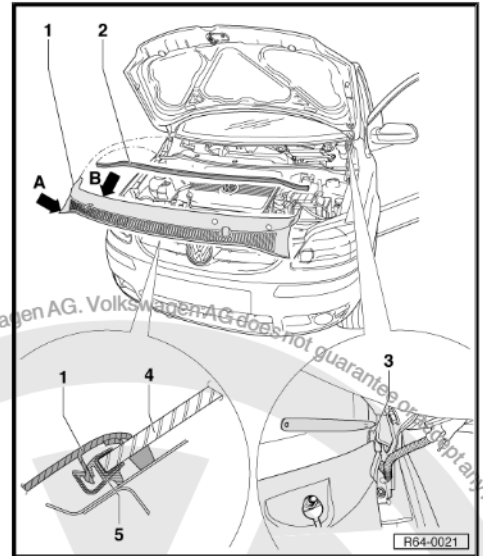
- Remove the windscreen wiper arms ⇒ Electrical system; Rep. gr. 92 ; Windscreen wiper
- Remove the sealing trim -2- at full length.
- With a plastic wedge (for instance, that of -V.A.G 1755-), press windscreen lower lining -3- tabs -1- forward from left and right between hinge and front lid.



- Carefully pull windscreen lower lining upward -1- from right -arrow A- out of fitting trim -5- on the windscreen -4-.

Installation:

- To better fasten the lower windscreen lining -1- to the fitting trim -5-, apply a neutral soap solution.
- Place windscreen lower lining -1- on the windscreen -5- fitting trim -4- and, starting from centre section -arrow B-, fit the windscreen lower lining to support -5- by slightly pressing it.
- With a plastic wedge (for instance, that of -V.A.G 1755-), place windscreen lower lining -3- covers -1- on installation position at left and right between hinge and front lid.
- Press sealing packing over lower lining -2-.
- Install the windscreen wiper arms ⇒ Electrical system; Rep. gr. 92 ; Windscreen wiper .



10.3 Floor lower lining - assembly overview

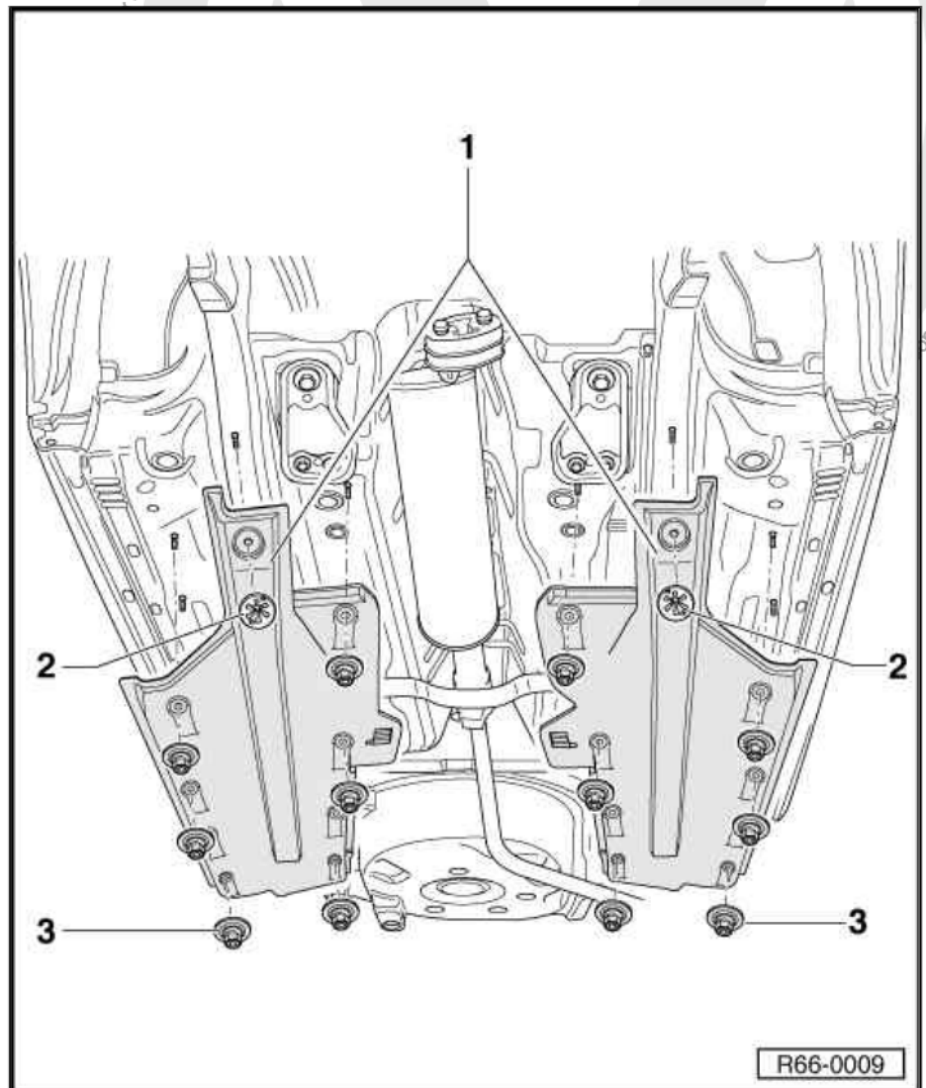
1 - Lining

2 - Clamping washer

- ☐ Torque: 1.5 Nm
- ☐ Fastened to body threaded pin
- ☐ On assembly it must be fastened, not pressed

3 - Plastic nut

- ☐ Torque: 1.5 Nm
- ☐ Fastened to lining through tabs
- ☐ Fastened to body threaded pin





10.4 Lower longitudinal member external lining - replace



WARNING

- ◆ *When handling chemicals follow the safety instructions ⇒ Chemical Products Manual; Rep. gr. 00*
- ◆ *Assignment of Chemical Materials ⇒ Electronic Parts Catalogue "ETKA"*

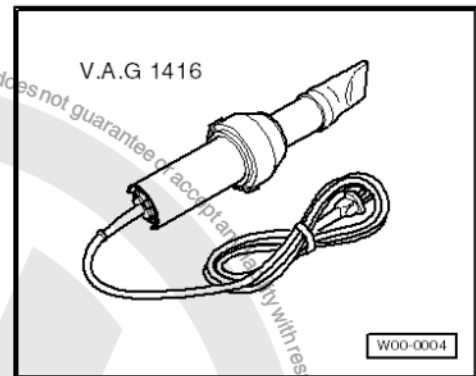


Note

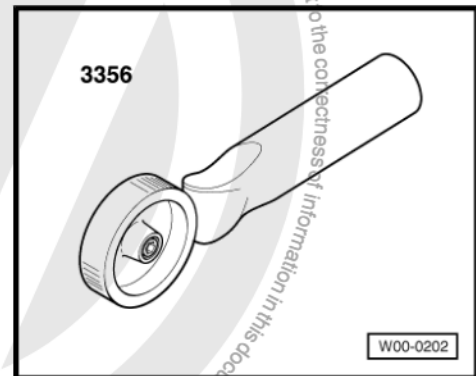
For versions: Space Cross / Suran Cross, Fox Rock in Rio etc., the following procedures are valid.

Special tools and workshop equipment required

- ◆ Hot air blower - VAG 1416-



- ◆ Pressure roll - 3356-





1 - Lower longitudinal member external lining (Crossfox)

- ☐ Self-adherent
- ☐ Glued under the external lining of the lower member
- ☐ Clean the external lining of the lower member with cleaning solution - D 009 401 04- .
- ☐ Remove adhesive tape liner, place lining and firmly press it with a pressure roll - 3356- . Operating temperature approx. 20°C.

a = 16.5 mm

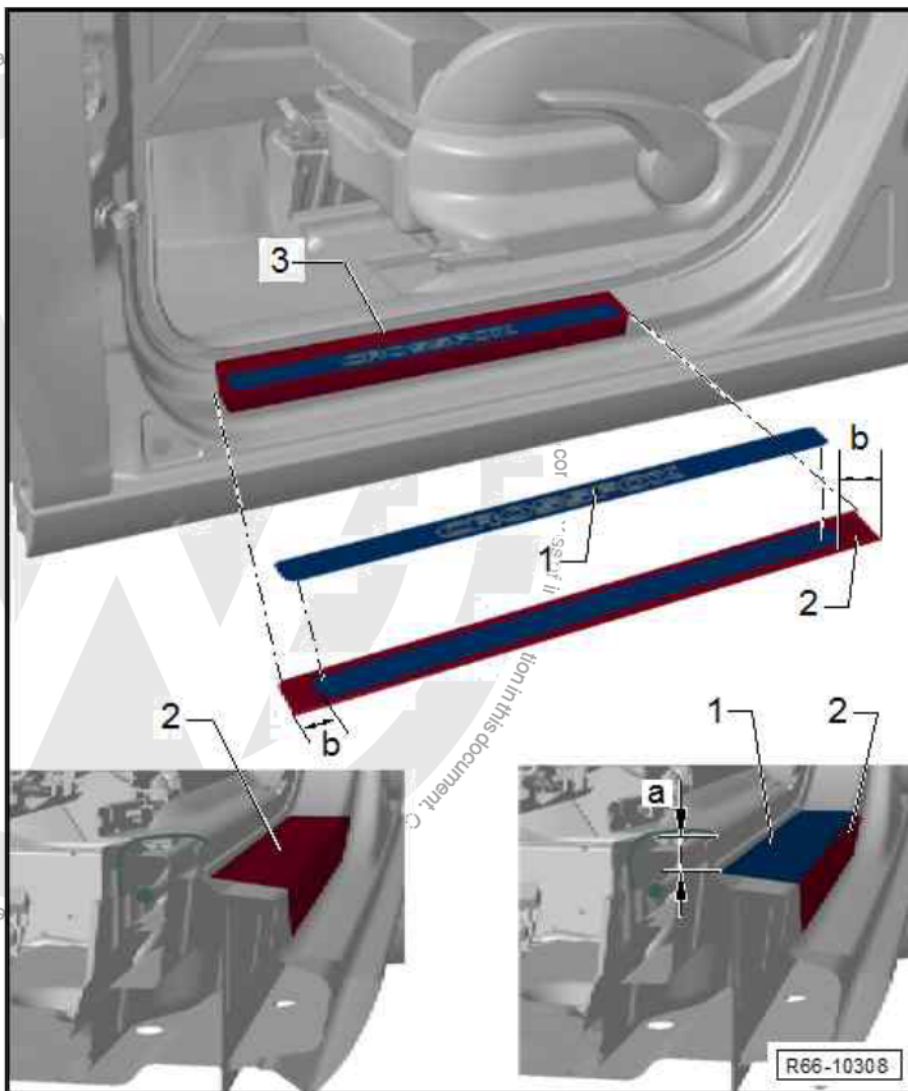
b = 15 mm

2 - Lower longitudinal member external lining

- ☐ Self-adherent
- ☐ Before removing, you must heat up the lining with the hot air blower - VAG 1416- .
- ☐ Remove the adhesive tape liner, place the lining (aligned with the curve on side panel -arrow-) and press it strongly pressure roll - 3356- . Operating temperature approx. 20°C.

3 - Front door external lining assembly area

- ☐ Clean the area using adhesive remover - D 002 000 A2- , then apply the cleaning solution - D 009 401 04- .



10.5 Pillar and door external lining - replace



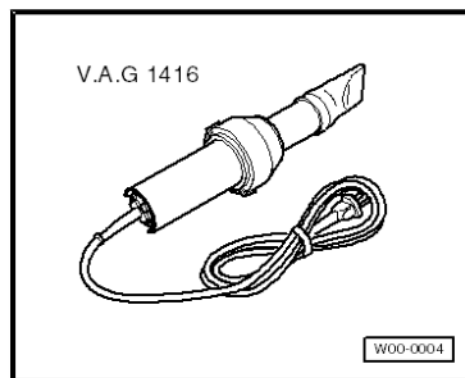
WARNING

- ◆ When handling chemicals follow the safety instructions ⇒ Chemical Products Manual; Rep. gr. 00
- ◆ Assignment of Chemical Materials ⇒ Electronic Parts Catalogue "ETKA"

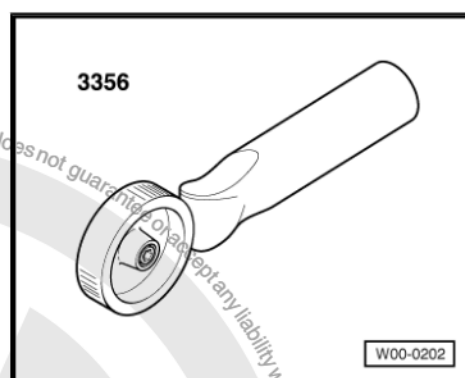
Special tools and workshop equipment required



◆ Hot air blower - VAG 1416-



◆ Pressure roll - 3356-





1 - Front door external lining assembly area

- ☐ Clean the area using adhesive remover - D 002 000 A2- , then apply the cleaning solution - D 009 401 04- .

2 - Rear door external lining assembly area (rear section)

- ☐ Clean the area using adhesive remover - D 002 000 A2- , then apply the cleaning solution - D 009 401 04- .

3 - Rear door external lining assembly area (front section)

- ☐ Clean the area using adhesive remover - D 002 000 A2- , then apply the cleaning solution - D 009 401 04- .

4 - Rear door external lining (rear section)

- ☐ Self-adherent
- ☐ Before removing, you must heat up the lining with the hot air blower - VAG 1416- .
- ☐ Remove adhesive tape liner, place lining and firmly press it with a pressure roll - 3356- . Operating temperature approx. 20°C.

5 - Pillar B external lining assembly area

- ☐ Clean the area using adhesive remover - D 002 000 A2- , then apply the cleaning solution - D 009 401 04- .

6 - Central pillar external lining

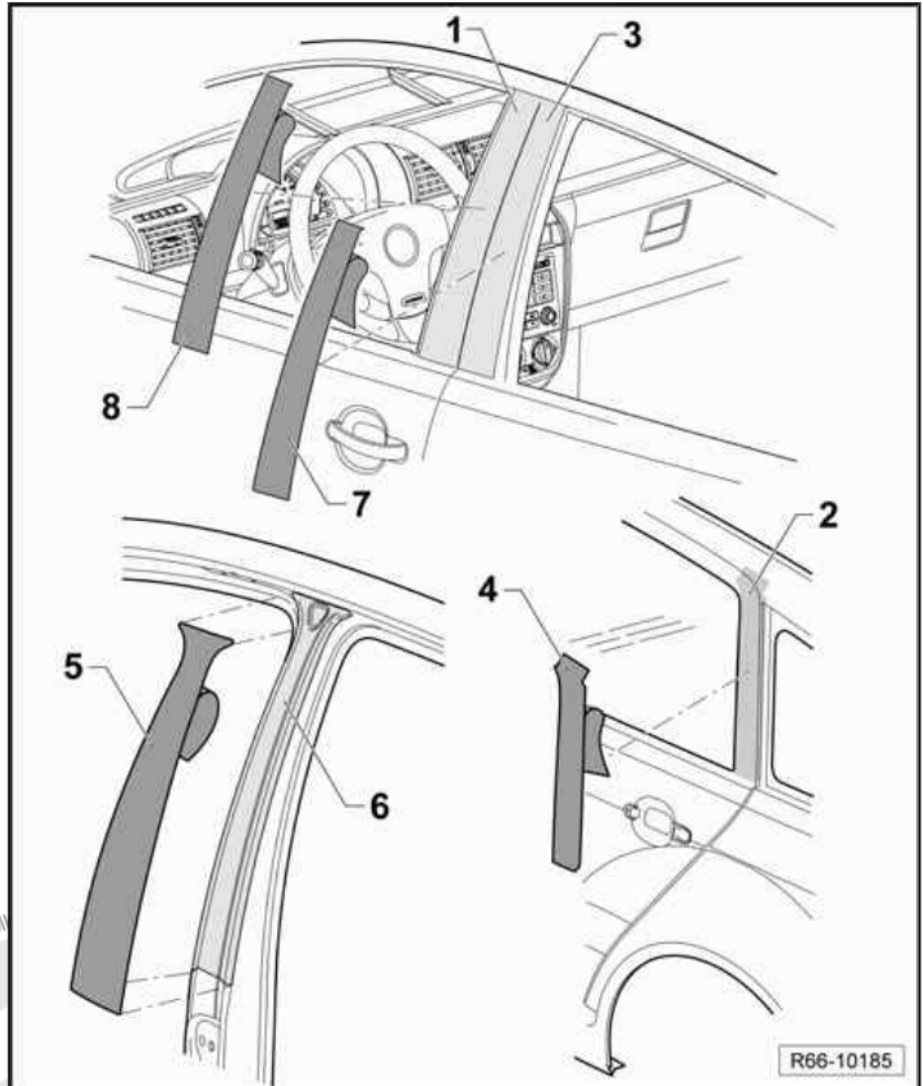
- ☐ Self-adherent
- ☐ Before removing, you must heat up the lining with the hot air blower - VAG 1416- .
- ☐ Remove adhesive tape liner, place lining and firmly press it with a pressure roll - 3356- . Operating temperature approx. 20°C.

7 - Rear door external lining

- ☐ Self-adherent
- ☐ Before removing, you must heat up the lining with the hot air blower - VAG 1416- .
- ☐ Remove adhesive tape liner, place lining and firmly press it with a pressure roll - 3356- . Operating temperature approx. 20°C.

8 - Front door external lining

- ☐ Self-adherent
- ☐ Before removing, you must heat up the lining with the hot air blower - VAG 1416- .
- ☐ Remove adhesive tape liner, place lining and firmly press it with a pressure roll - 3356- . Operating temperature approx. 20°C.



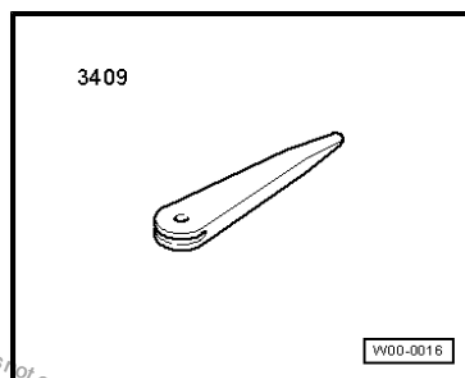


11 Spoiler grids and bumper protector trims

11.1 Front protector grilles - assembly over-view

Special tools and workshop equipment required

- ♦ Wedge - 3409-



1 - Front protector

- ☐ Remove and install
⇒ [page 106](#)

2 - Left front protector grid

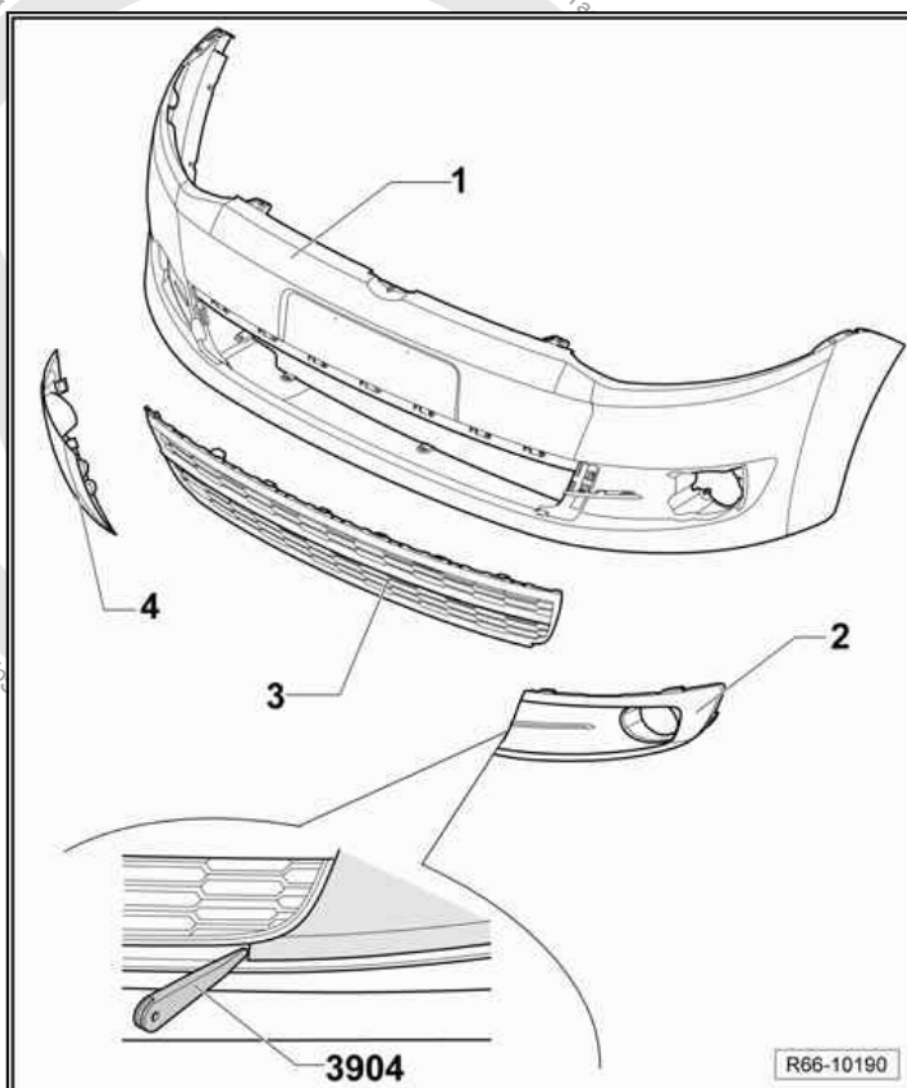
- ☐ fastened to front protector by fastening tabs.
- ☐ Unlock grille with a wedge - 3409- .

3 - Front protector's central grid

- ☐ fastened to front protector by fastening tabs.
- ☐ remove the front protector to access the tabs.
- ☐ carefully disengage the securing tabs from the centre grille.

4 - Right front protector's side grid

- ☐ fastened to front protector by fastening tabs.
- ☐ Unlock grille with a wedge - 3409- .





11.2 Grilles, front protector trim, spoiler (Crossfox and Space Cross / Suran Cross) - assembly overview

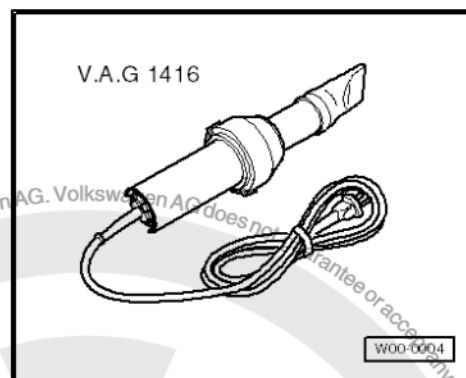


WARNING

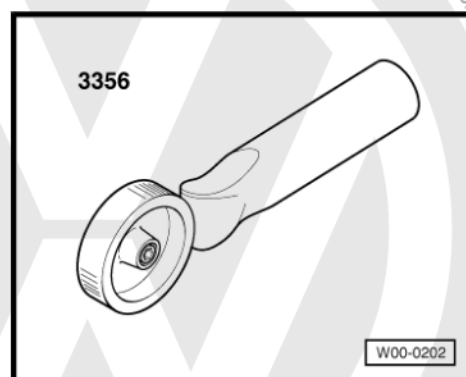
- ◆ *When handling chemicals follow the safety instructions ⇒ Chemical Products Manual; Rep. gr. 00*
- ◆ *Assignment of Chemical Materials ⇒ Electronic Parts Catalogue "ETKA"*

Special tools and workshop equipment required

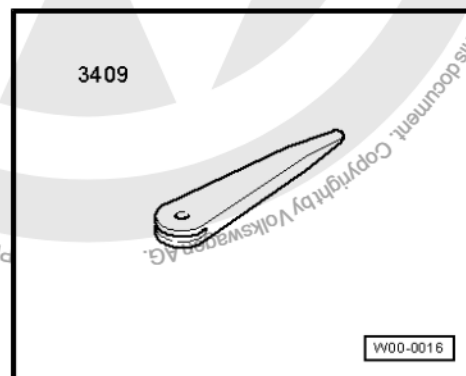
- ◆ Hot air blower - VAG 1416-



- ◆ Pressure roll - 3356-



- ◆ Wedge - 3409-





1 - Double-sided adhesive tape

- ☐ The adhesive tape adhesion area must be completely free of dirt.
- ☐ Under no circumstances should the self-adhesive surface of the tape be touched.

2 - Front protector

- ☐ Remove and install
⇒ [page 106](#)

3 - Front protector trim

- ☐ Self-adherent
- ☐ Remove circlips -4- and the screw -6-.
- ☐ Before removing, you must heat up the lining with the hot air blower - VAG 1416- .
- ☐ Clean the area using adhesive remover - D 002 000 A2- , then apply the cleaning solution - D 009 401 04- .
- ☐ Remove the adhesive tape liner, position the trim. Operating temperature approx. 20°C.

4 - Circlip

5 - Speed nut

6 - Bolt

- ☐ Torque: 1.5 Nm

7 - Left front protector grid

- ☐ fastened to front protector by fastening tabs.
- ☐ Unlock grille with a Wedge - 3409- .

8 - Bolt

- ☐ Torque: 1.5 Nm

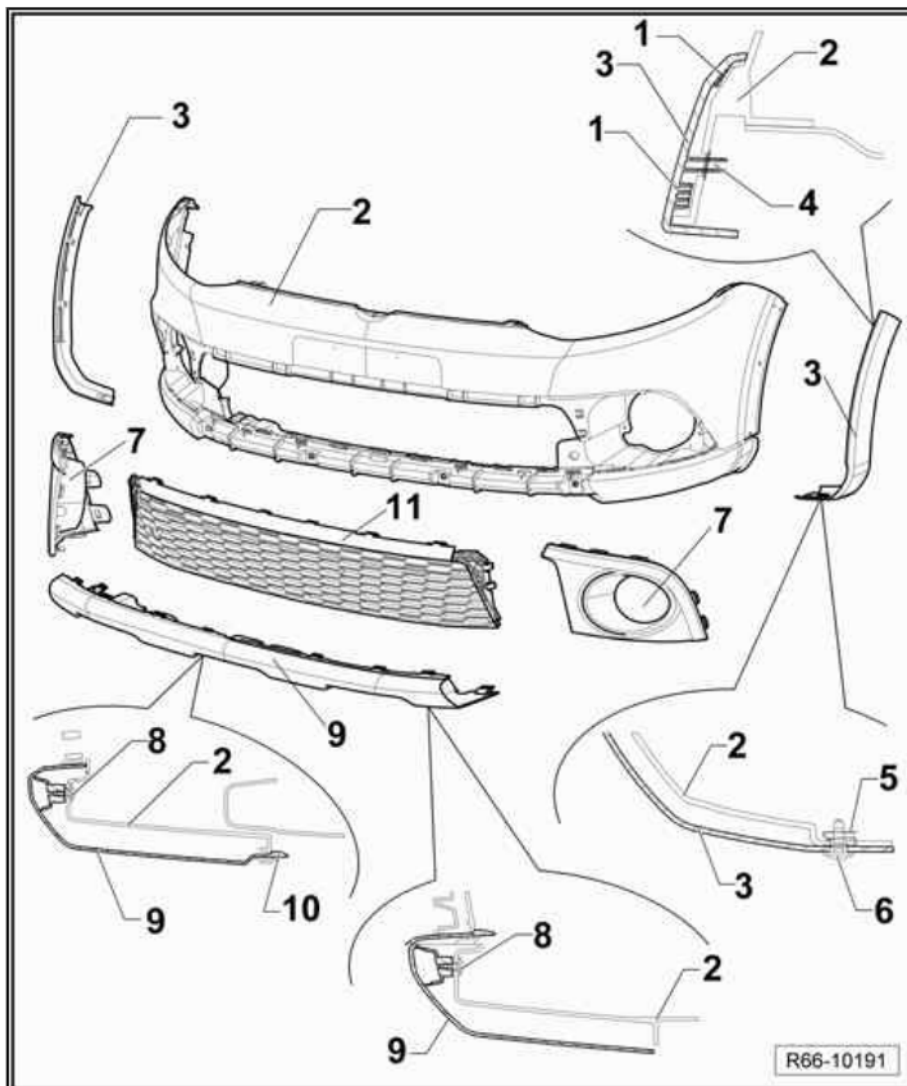
9 - Front spoiler

- ☐ Remove
 - Remove the front bumper protection.
 - Remove screws -8- and disengage the lining -10-.
 - Disengage and remove the spoiler.
- ☐ Install
 - Installation is performed in the reverse sequence to the removal.

10 - Fitting tab

11 - Front protector's central grid

- ☐ fastened to front protector by fastening tabs.
- ☐ the side grilles must be removed.
- ☐ remove the front protector to access the tabs.





- ☐ carefully disengage the securing tabs from the centre grille.

11.3 Rear protector trim, spoiler (Crossfox) - assembly overview



WARNING

- ◆ When handling chemicals follow the safety instructions ➔ Chemical Products Manual, Rep. gr. 00
- ◆ Assignment of Chemical Materials ➔ Electronic Parts Catalogue "ETKA"

1 - Rear protector trim

- ☐ Self-adherent
- ☐ Remove circlips -4- and the screw -6-.
- ☐ Before removing, you must heat up the lining with the hot air blower - VAG 1416-.
- ☐ Clean the area using adhesive remover - D 002 000 A2-, then apply the cleaning solution - D 009 401 04-.
- ☐ Remove the adhesive tape liner, position the trim. Operating temperature approx. 20°C.

2 - Rear wheel case protector

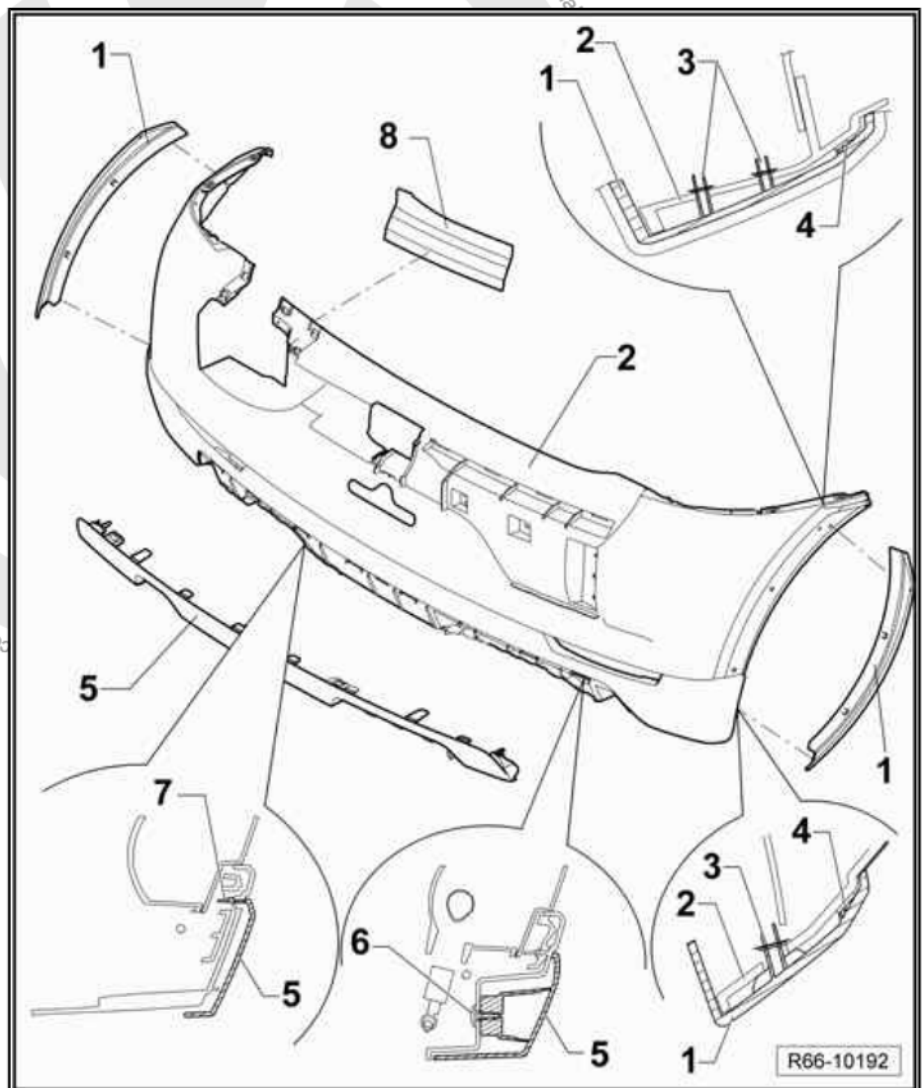
3 - Circlip

4 - Double-sided adhesive tape

- ☐ The adhesive tape adhesion area must be completely free of dirt.
- ☐ Under no circumstances should the self-adhesive surface of the tape be touched.

5 - Rear spoiler

- ☐ Remove
 - Remove the rear bumper protection.
 - Remove screws -2- and screw -4-.
 - Disengage and remove the spoiler.
- ☐ Install
 - Installation is performed in the reverse sequence to the removal.





- 6 - Bolt
- 7 - Fitting tab
- 8 - Rear protector extension
 - ☐ for spare wheel support.

11.4 Rear protector trim, spoiler (Space Cross / Suran Cross) - assembly overview



WARNING

- ◆ When handling chemicals follow the safety instructions ⇒ *Chemical Products Manual; Rep. gr. 00*
- ◆ Assignment of Chemical Materials ⇒ *Electronic Parts Catalogue "ETKA"*

- 1 - Rear protector
 - ☐ Remove and install
⇒ [page 121](#)

- 2 - Version identification cover

- ☐ Remove
 - Remove rear bumper protector.
 - Remove rear protector trim.
 - Remove the spoiler.
 - Disengage cover fastening tabs and remove the cover.
- ☐ Install
 - Installation is performed in the reverse sequence to the removal.

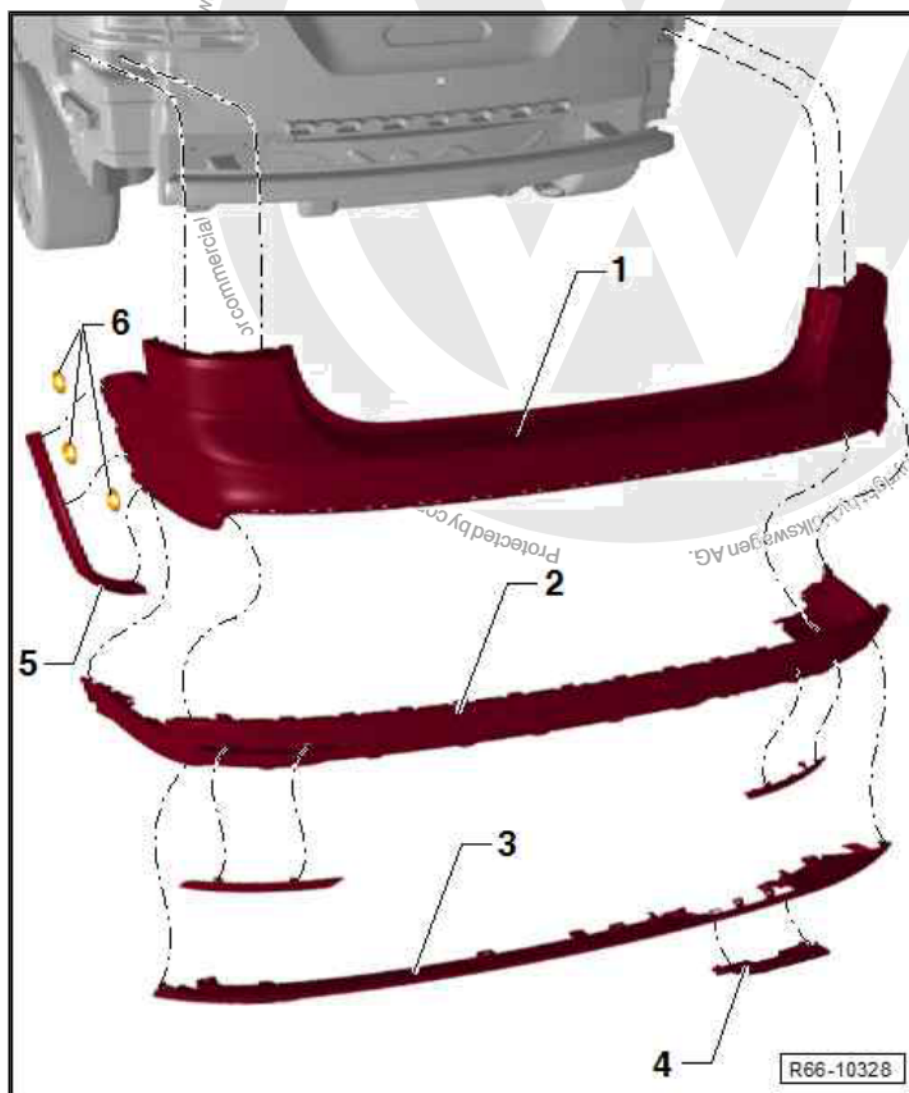
- 3 - Rear spoiler

- ☐ Remove
 - Remove the rear bumper protection.
 - Disengage spoiler fastening tabs and remove the spoiler.
- ☐ Install
 - Installation is performed in the reverse sequence to the removal.

- 4 - Tow hook cover

- 5 - Rear protector trim

- ☐ The adhesive tape adhesion area must be completely free of dirt.





- ☐ Under no circumstances should the self-adhesive surface of the tape be touched.
- ☐ Remove:
- ☐ Remove circlips -4- and the screw -6-.
- ☐ Before removing, you must heat up the lining with the hot air blower - VAG 1416- .
- ☐ Clean the area using adhesive remover - D 002 000 A2- , then apply the cleaning solution - D 009 401 04- .
- ☐ Remove the adhesive tape liner, position the trim. Operating temperature approx. 20°C.

6 - Circlip

- ☐ 3 units



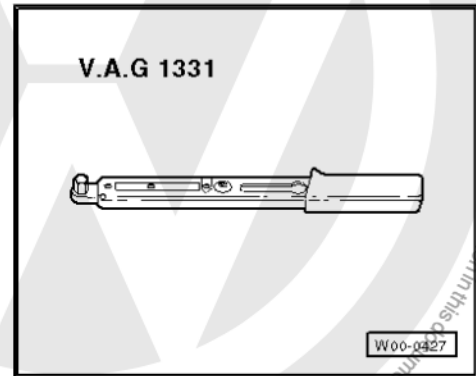


12 Spare wheel support (CrossFox)

12.1 Spare wheel support - remove and install

Special tools and workshop equipment required

- ◆ Torque wrench - 5 to 50 Nm (1/2" drive) - VAG 1331-



Removal:

- Remove the spare wheel.
- Remove the internal lining of spare wheel support
⇒ [page 278](#) .
- Remove spare wheel support internal lining ⇒ [page 279](#) .
- Remove the rear bumper protection ⇒ [page 111](#) .
- Remove fastenings -1- of spare wheel support bearing.
- Detach connector -3- from the switch on the spare wheel unlocking support bracket - E727- harness.
- With the help of an assistant, remove the mounting bracket bolts -2- (Torque: 35 Nm).

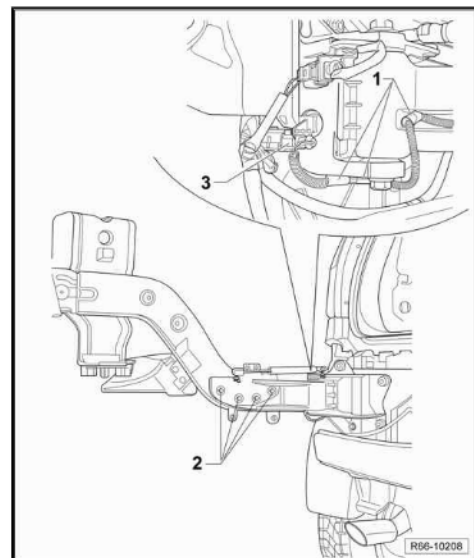
Installation:



Note

Tighten the screws -2-.

- Installation is performed in the reverse sequence to the removal.

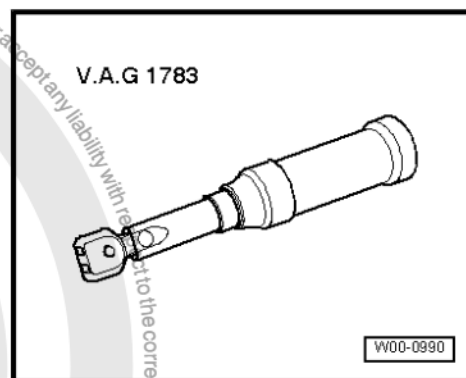


12.2 Spare wheel support internal lining - remove and install

Special tools and workshop equipment required



- ◆ Torque wrench 2 to 10 Nm - VAG 1783-

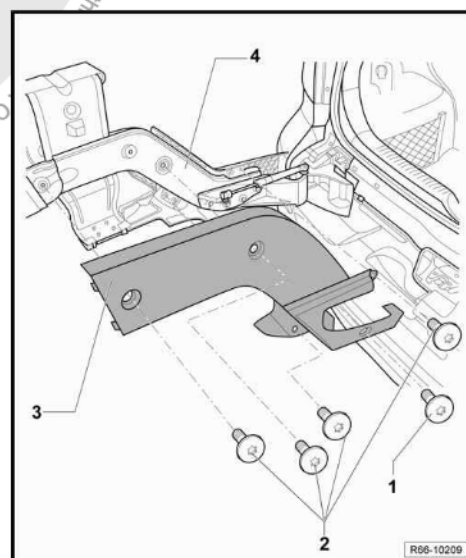


Removal:

- Remove the spare wheel.
- Remove the screws -1- (Torque: 2 Nm).
- Remove the screws -2- (Torque: 3 Nm).
- Remove the lining -3- from the spare wheel mounting -4-.

Installation:

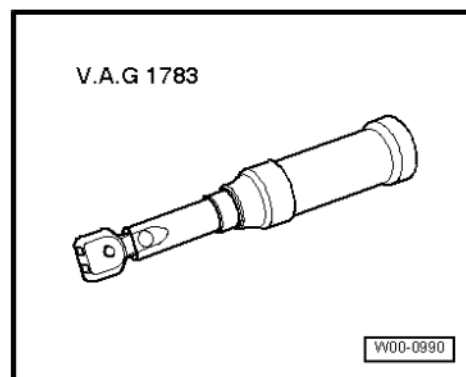
- Installation is performed in the reverse sequence to the removal.



12.3 Spare wheel support external lining - remove and install

Special tools and workshop equipment required

- ◆ Torque wrench 2 to 10 Nm - VAG 1783-



Removal:

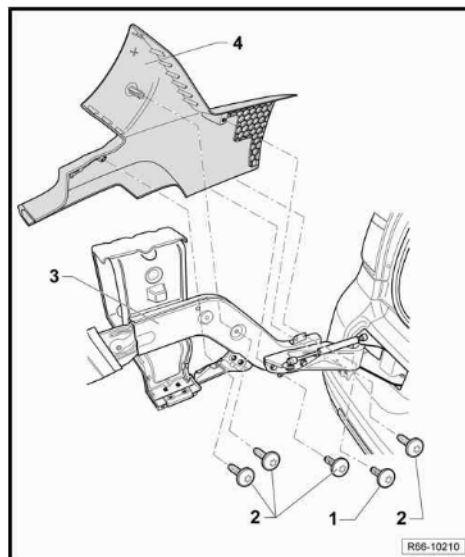
- Remove spare wheel.



- Remove the internal lining of spare wheel support
⇒ [page 278](#) .
- Remove the screws -1- (Torque: 2 Nm).
- Remove the screws -2- (Torque: 3 Nm).
- Remove the lining -4- from the spare wheel mounting -3-.

Installation:

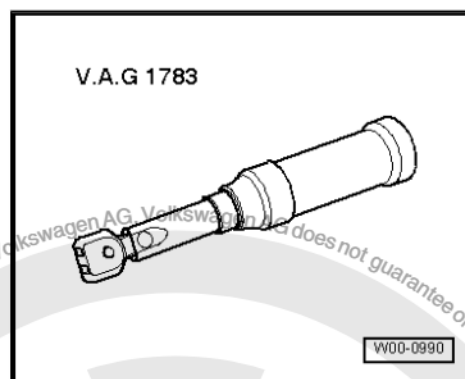
- Installation is performed in the reverse sequence to the removal.



12.4 Knob internal lining - remove and install

Special tools and workshop equipment required

- ◆ Torque wrench 2 to 10 Nm - VAG 1783-



Removal:

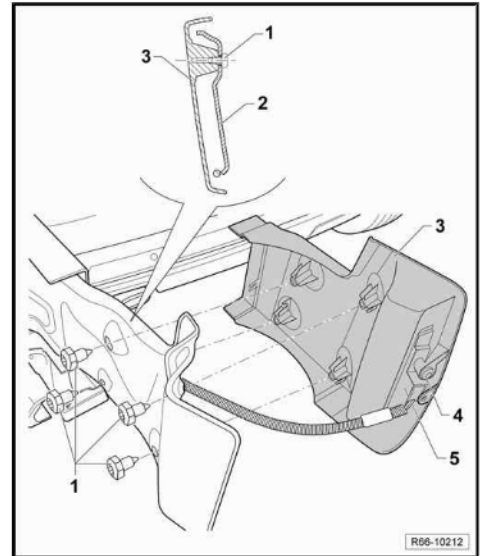
- Remove the spare wheel.
- Remove knob external lining ⇒ [page 281](#) .
- Remove the screws -1- (Torque: 2 Nm).



- Loosen screw -4- and disengage the Spare wheel release switch - E727- -5- from lining -3-.

Installation:

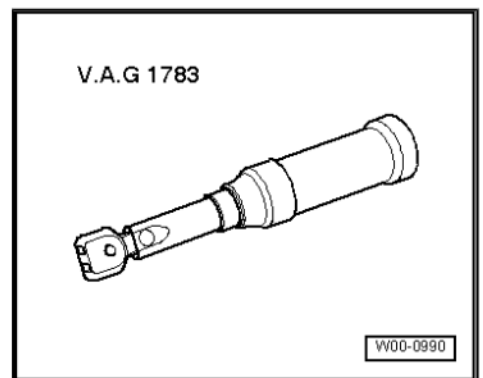
- Installation is performed in the reverse sequence to the removal.



12.5 Puller external lining - remove and install

Special tools and workshop equipment required

- ◆ Torque wrench 2 to 10 Nm - VAG 1783-

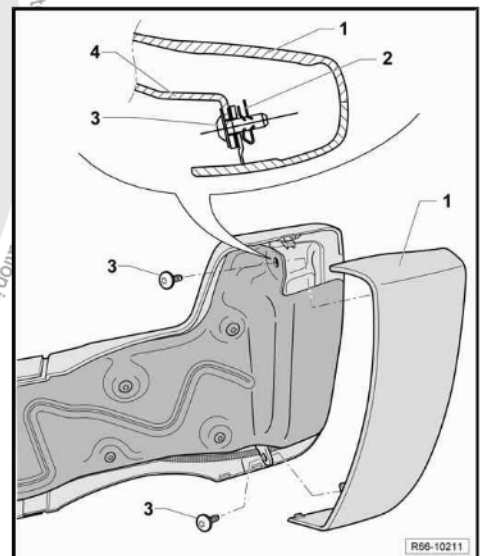


Removal:

- Remove the spare wheel.
- Remove the screws -3- (Torque: 2 Nm).
- Remove the lining -1- from the spare wheel mounting -4-.

Installation:

- Installation is performed in the reverse sequence to the removal.





12.6 Spare wheel support shock absorber - remove and install

Removal:

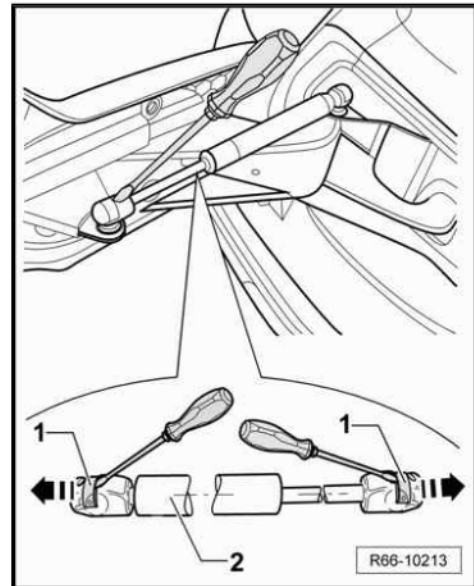
- Remove spare wheel support.
- Place a small screwdriver underneath the spring clip -1-.
- Raise the clip -1- enough to allow the clip to move over the ball joint housing -towards the arrow-.
- Pull spare wheel support shock absorber -2- from spherical pins.

After removing shock absorber -2-, immediately move the clamp -1- backwards.



WARNING

Be careful when installing the shock absorber. The spring clamp cannot be completely disengaged from ball joint housing; otherwise, it will be damaged. The shock absorber can disengage from the spherical pins and result into a serious accident.



Installation:

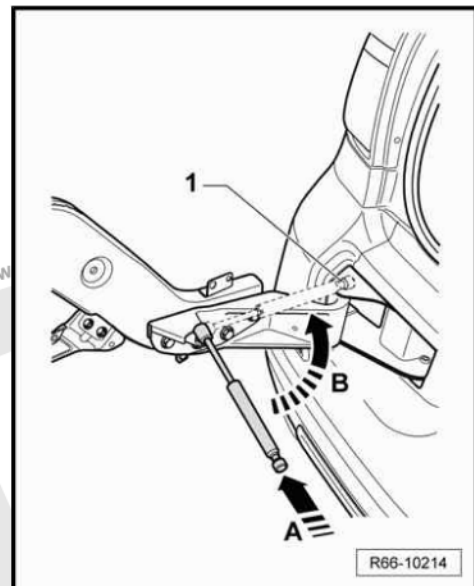
- Press shock absorber body against the rod towards -arrow A-.



Note

Use safety gloves.

- When distending the shock absorber rod, place it -arrow B-. When reaching the spherical pin -1-, press shock absorber to fit the shock absorber's eyelet.



12.7 Spare wheel support shock absorber - replace

- Remove the shock absorber ⇒ [page 282](#) .

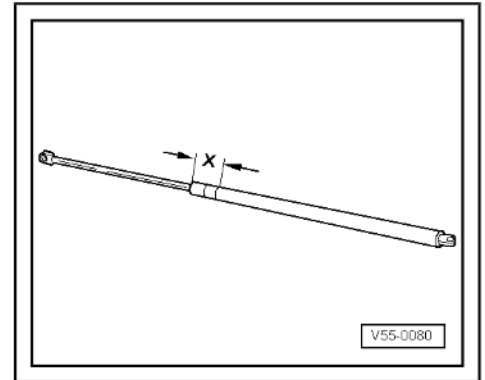


- Fasten the gas shock absorber to the vise, in area
-x = 50 mm-.



WARNING

The shock absorber must be fastened in this area. Otherwise, accidents may occur!



- In this area, carefully saw the spare wheel support shock absorber cylinder in order for oil to drain out.



Note

- ◆ While cutting, wear safety goggles.
- ◆ The area where cutting is processed must be covered with a cloth.
- ◆ Both the oil and the cloth must be duly discarded.
- Install the new shock absorber.

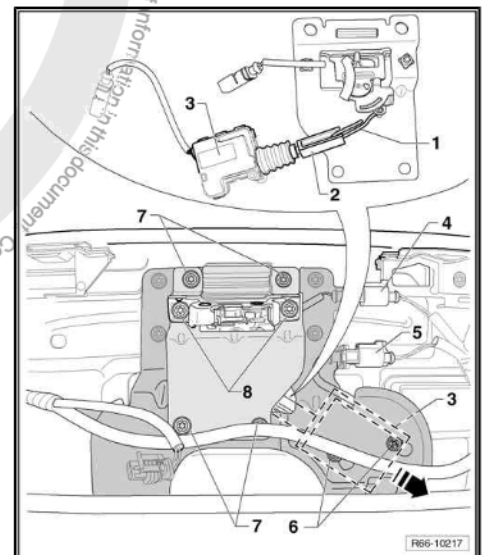
12.8 Spare wheel lock motor -V340- - remove and install

Removal:

- Remove spare wheel.
- Remove the internal lining of spare wheel support
⇒ [page 278](#) .
- Remove spare wheel support internal lining ⇒ [page 279](#) .
- Remove rear bumper protector.
- Remove bolts -6- from the spare wheel lock motor - V340-
-3- and pull it in the direction of the -arrow-.
- Disconnect the connector -5- from spare wheel lock motor -
V340- -3-.
- Disconnect the connector -4- from freewheel locking control
lamp switch - F108- .
- Remove the bolts -7-.
- Remove latch along with the support and spare wheel lock
motor - V340- .
- Remove latch by disengaging it from -1- motor operating rod
-3-.

Installation:

- Installation is performed in the reverse sequence to the re-
moval.





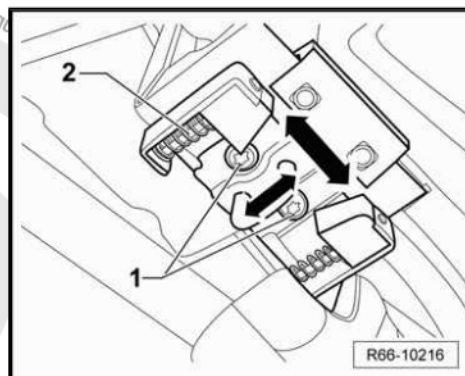
12.9 Spare wheel latch buffer - remove and install

Removal:

- Remove screws -1- and remove the buffer -2-.

Removal:

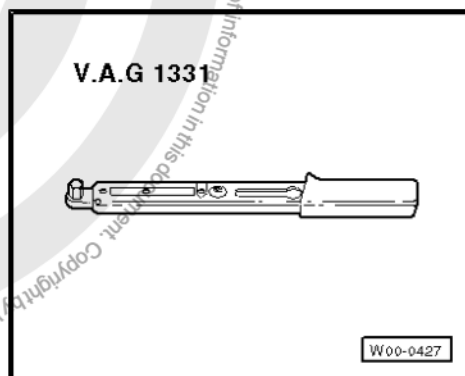
- Installation is performed in the reverse sequence to the removal.
- Adjust the striker ➔ [page 284](#) .



12.10 Spare wheel latch buffer - adjust

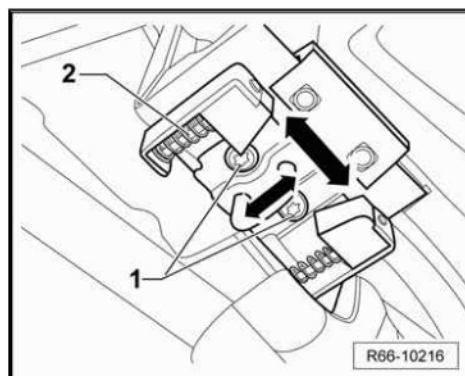
Special tools and workshop equipment required

- ♦ Torque wrench - 5 to 50 Nm (1/2" drive) - VAG 1331-



Adjust:

- Loosen the bolts -1-.
- Position buffer -2- and tighten the screws -1- temporarily.
- Close the spare wheel support buffer and check for correct striker locking.
- Final tighten the screws -1- (Torque: 8 Nm).



12.11 Spare wheel support latch - remove and install

Special tools and workshop equipment required



- ◆ Torque wrench - 5 to 50 Nm (1/2" drive) - VAG 1331-

V.A.G 1331



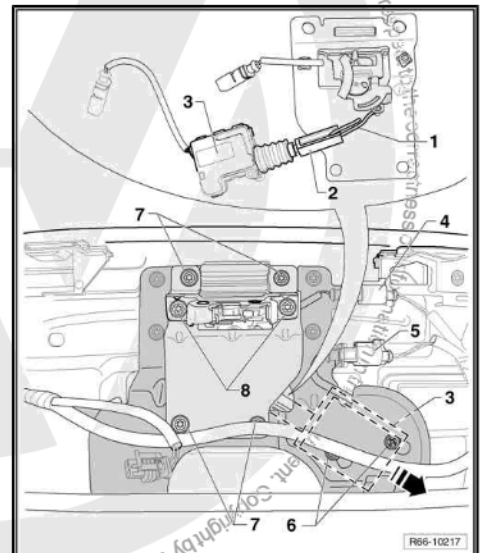
W00-0427

Removal:

- Remove spare wheel.
- Remove the internal lining of spare wheel support
⇒ [page 278](#) .
- Remove spare wheel support internal lining ⇒ [page 279](#) .
- Remove rear bumper protector.
- Remove the bolts -8-.
- Remove bolts -6- from the spare wheel lock motor - V340-
-3- and pull it in the direction of the -arrow-.
- Disconnect the connector -5- from spare wheel lock motor -
V340- -3-.
- Disconnect the connector -4- from freewheel locking control
lamp switch - F108- .
- Remove the bolts -7-.
- Remove latch along with the support and spare wheel lock
motor - V340- .
- Remove the latch.

Installation:

- Installation is performed in the reverse sequence to the re-
moval.
- Adjust the latch ⇒ [page 285](#) .



R66-10217

12.12 Spare wheel support latch - adjust

Special tools and workshop equipment required

- ◆ Torque wrench - 5 to 50 Nm (1/2" drive) - VAG 1331-

V.A.G 1331

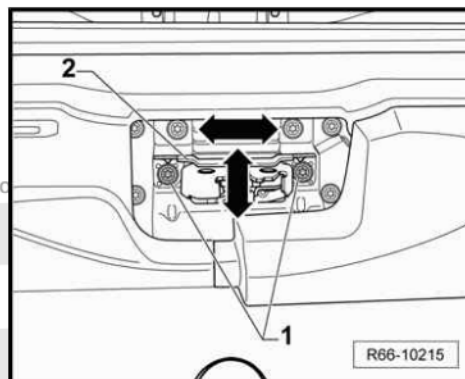


W00-0427



Adjust:

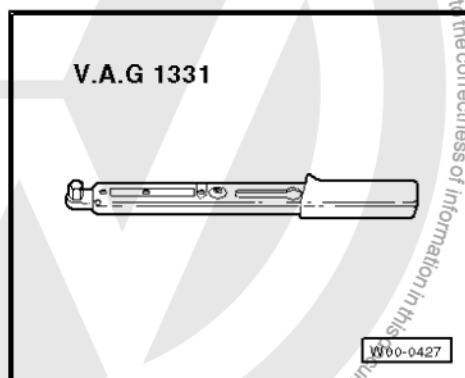
- Loosen the bolts -1-.
- Position latch -2- and tighten the screws -1- temporarily.
- Close the spare wheel support buffer and check for correct latch locking.
- Final tighten the screws -1- (Torque: 8 Nm).



12.13 Spare wheel support bearing - remove and install

Special tools and workshop equipment required

- ♦ Torque wrench - 5 to 50 Nm (1/2" drive) - VAG 1331-

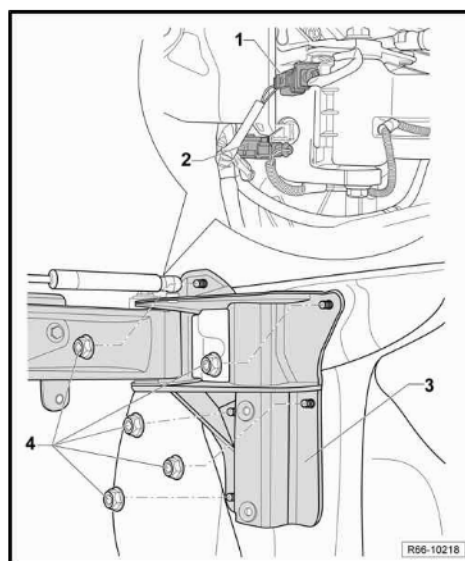


Removal:

- Remove the spare wheel.
- Remove the internal lining of spare wheel support
⇒ [page 278](#) .
- Remove spare wheel support internal lining ⇒ [page 279](#) .
- Remove the rear bumper protection ⇒ [page 112](#) .
- Remove rear protector support ⇒ [page 114](#) .
- Detach connector -2- from the switch on the spare wheel unlocking support bracket - E727- harness.
- Disconnect connector -1- from harness of the spare wheel unlocking support switch - F330- .
- With the help of an assistant, remove the bearing nuts -4- (Torque: 20 Nm).

Installation:

- Installation is performed in the reverse sequence to the removal.
- Adjust the latch ⇒ [page 285](#) .
- Adjust the striker ⇒ [page 284](#) .

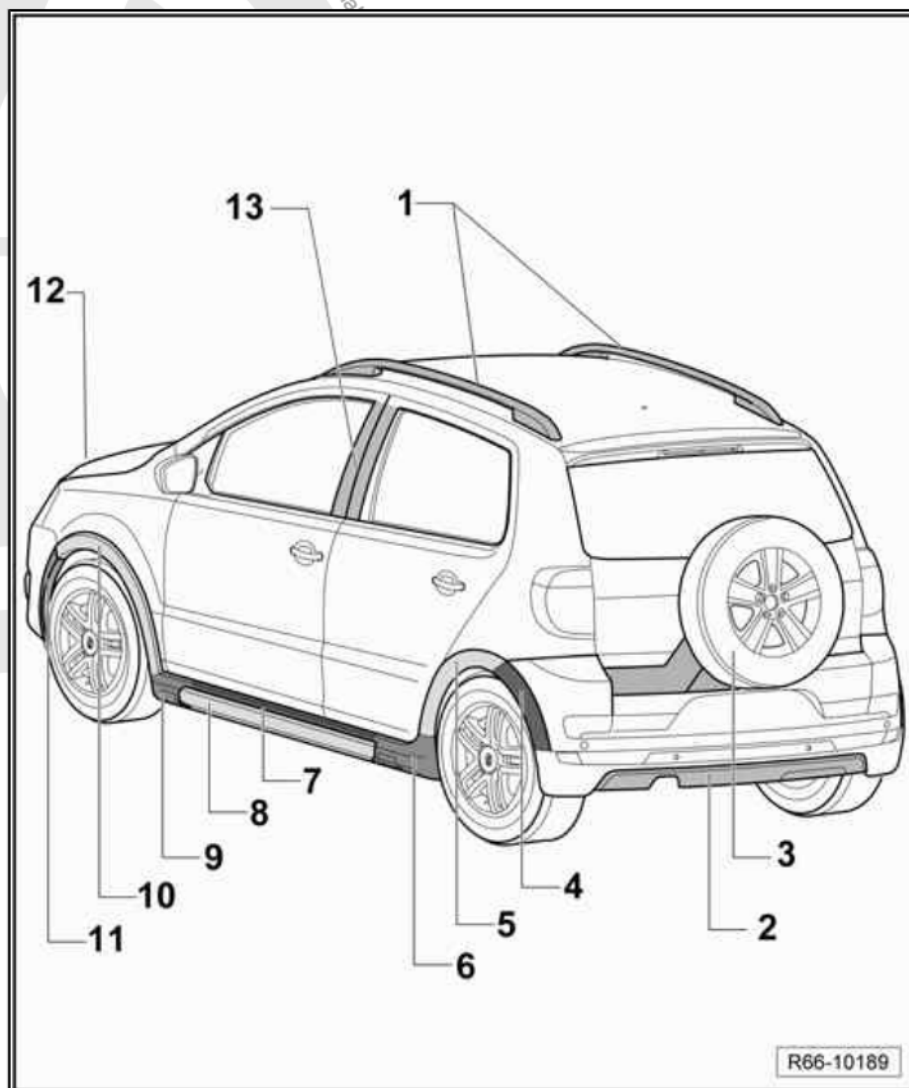




13 Crossfox components

13.1 Assembly overview

- 1 - Roof rack
 - ☐ Remove and install
⇒ [page 177](#)
- 2 - Rear spoiler
 - ☐ Remove and install
⇒ [page 275](#)
- 3 - Spare wheel support
 - ☐ Remove and install
⇒ [page 278](#)
- 4 - Rear bumper trim
 - ☐ Replace ⇒ [page 275](#)
- 5 - Rear side panel trim
 - ☐ Replace ⇒ [page 222](#)
- 6 - Side footboard rear lining
 - ☐ Replace ⇒ [page 231](#)
- 7 - Side footboard upper lining
 - ☐ Replace ⇒ [page 232](#)
- 8 - Side footboard
 - ☐ Replace ⇒ [page 226](#)
- 9 - Side footboard rear lining
 - ☐ Fastened to side footboard ⇒ [page 231](#)
- 10 - Front wing trim
 - ☐ Replace ⇒ [page 224](#)
- 11 - Front bumper trim
 - ☐ Replace ⇒ [page 273](#)
- 12 - Front spoiler
 - ☐ Remove and install
⇒ [page 273](#)
- 13 - Pillar and door external lining
 - ☐ Replace ⇒ [page 269](#)





14 Space Cross / Suran Cross components

14.1 Assembly overview

1 - Roof rack

- ☐ Remove and install
⇒ [page 181](#)

2 - Rear spoiler

- ☐ Remove and install
⇒ [page 276](#)

3 - Spoiler

- ☐ Remove and install
⇒ [page 169](#)

4 - Rear bumper trim

- ☐ Replace ⇒ [page 276](#)

5 - Rear side panel trim

- ☐ Replace ⇒ [page 222](#)

6 - Side footboard rear lining

- ☐ Replace ⇒ [page 231](#)

7 - Rear doors external lining

- ☐ Replace ⇒ [page 269](#)

8 - Rear doors external lining

- ☐ Replace ⇒ [page 269](#)

9 - Front doors external lining

- ☐ Replace ⇒ [page 269](#)

10 - Side footboard

- ☐ Replace ⇒ [page 226](#)

11 - Rear door trim

- ☐ Replace ⇒ [page 251](#)

12 - Front door trim

- ☐ Replace ⇒ [page 246](#)

13 - Side footboard upper lining

- ☐ Replace ⇒ [page 232](#)

14 - Side footboard front lining

- ☐ Replace ⇒ [page 225](#)

15 - Front wing trim

- ☐ Replace ⇒ [page 224](#)

16 - Front bumper trim

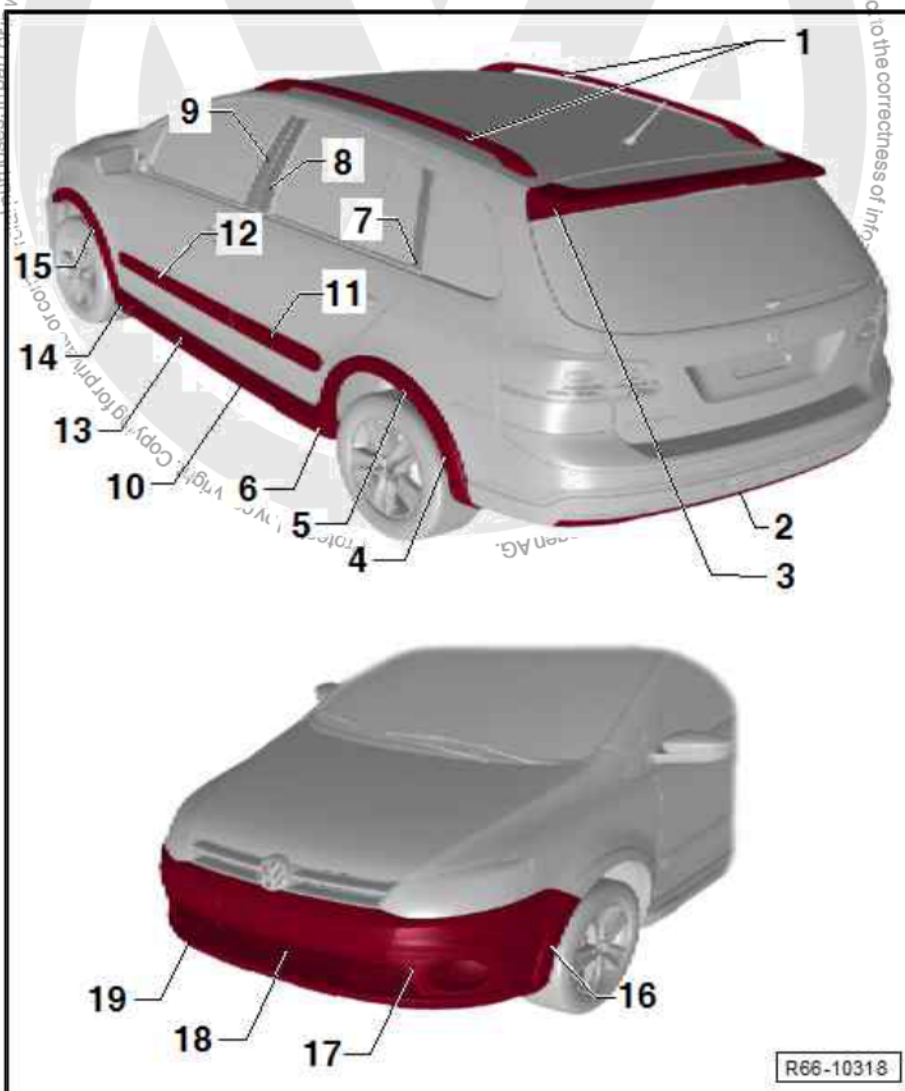
- ☐ Replace ⇒ [page 273](#)

17 - Front protector's side grille

- ☐ Remove and install ⇒ [page 273](#)

18 - Front protector's central grille

- ☐ Remove and install ⇒ [page 273](#)





19 - Front spoiler

- ☐ Replace ➔ [page 273](#)

